

Product Data Sheet



BRAND NAME VJ ER2594

AWS/ASME Class ER2594

SPECIFICATION SFA A5.9

Features and Applications :

VJ ER2594 is designed for welding wrought, forged, and cast super duplex stainless steels, typically used in the as-welded condition. It weld metal chemistry and mechanical properties, delivering high tensile and yield strength, along with exceptional resistance to stress corrosion cracking (SCC) and pitting corrosion.

CHEMICAL COMPOSITION :

All Weld Metal (%)			
TYPICAL	Max	TYPICAL	Max
C	0.03	Mn	1.50
Cr	25.00	Si	0.50
Ni	9.00	S	0.015
Mo	3.50	P	0.010
Cu	0.50	N	0.22

MECHANICAL PROPERTIES OF WELD METAL

All Weld Metal - As weld	
Properties	Typical
UTS (MPa)	790
EI (%)	24

DIMENSIONS:

Dimension (mm)	
GMAW	GTAW
0.80	1.6
1.20	2.0
1.60	2.4
	3.2

GMAW CURRENT : DC (+)	SHIELDING GAS: ARGON
GTAW CURRENT : DCEN	SHIELDING GAS: ARGON

PACKING :

GTAW : 5 kg wire put in an air-tight polythene bag and finally packed in a plastic container. Identification AWS code is punched on side of wire.

GMAW :The wire can be supplied in plastic spool packed in a cardboard box weighing 15.0 kg.

WELDING POSITION:

