Product Data Sheet

BRAND NAME VJ 2594

AWS/ASME Class E 2594 -16

SPECIFICATION SFA 5.4

Features and Applications :

VJ 2594 is a high-performance super duplex electrode, offering excellent corrosion resistance and superior mechanical properties. With outstanding resistance to chloride stress corrosion cracking (CSCC) for over 600 hours and strong pitting corrosion resistance, it's applications like offshore platforms, petrochemical plants, oil & gas industries, and seawater environments.

CHEMICAL COMPOSITION :

All Weld Metal (%)			
TYPICAL	**Max**	**TYPICAL**	**Max**
C	0.04	Cr	24.0-27.0
Mn	0.50-2.0	Ni	8.0-10.50
Si	1.00	Mo	3.50-4.50
S	0.020	N	0.20-0.30
P	0.030		

MECHANICAL PROPERTIES OF WELD METAL

All Weld Metal - As Welded	
Properties	**Typical**
UTS (MPa)	790
El (%)	15 Min
Charpy V at -20°C (J)	27 Min
Charpy V at 20°C (J)	40 Min
Hardness (BHN)	300 Max

DIMENSIONS & CURRENT DATA

Dimension (mm)	Current (A)		Packing (Pcs)
Dia x Length	**Min**	**Max**	**Qty / Pkt**
2.50 x 350	60	90	150
3.15 x 350	80	120	100
4.00 x 350	110	150	75

PITTING RESISTANCE EQUIVALENT NUMBER : Meets the requirement of PREN > 40

CORROSION PROPERTY : Weld Metal meets ASTM G123 (CSCC), G48 (Pitting Corrosion), A923 (Metallogrpahy) requirements in as welded condition

CURRENT : AC/DC (+)

WELDING POSITION:

OTHER DATA:

Redrying: The electrodes should be redried at 250°C for 1 hour.