

Product Data Sheet



BRAND NAME VJ 2595
AWS/ASME Class E2595 -16
SPECIFICATION SFA 5.4

Features and Applications :

VJ 2595 is a ferritic-austenitic super duplex electrode offering high strength and excellent resistance to stress corrosion cracking, pitting, and crevice corrosion. It is ideal for welding super duplex stainless steels like UNS S32550, S32750, and S32760 (wrought). With an operating range of -50°C to +250°C, it is highly suited for offshore applications.

CHEMICAL COMPOSITION :

All Weld Metal (%)			
TYPICAL	Max	TYPICAL	Max
C	0.03	Cr	25.50
Mn	1.20	Ni	9.40
Si	0.50	Mo	3.80
Cu	0.70	N	0.250
W	0.70		

MECHANICAL PROPERTIES OF WELD METAL

All Weld Metal - As Welded	
Properties	Typical
YS (Mpa)	640
UTS (MPa)	790
El (%)	24

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

CURRENT : AC/DC (+)

WELDING POSITION:



OTHER DATA:

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