

# LINCOLNWELD® 2594

Stainless ▪ AWS ER2594

## KEY FEATURES

- A super-duplex grade electrode that provides matching chemistry and mechanical property characteristics to wrought super-duplex alloys such as 2507 and Zeron 100, as well as to super-duplex casting alloys (ATSM A890)
- The electrode is over-alloyed with nitrogen to provide the optimum ferrite/austenite ratio in the finished weld resulting in high tensile and yield strength and superior resistance to stress corrosion, cracking (SCC) and pitting corrosion
- Q2 Lot® - Certificates showing actual wire chemistry available online

## CONFORMANCES

AWS A5: ER2594

ABS: ER2594

## TYPICAL APPLICATIONS

- Process Pipework
- Pumps and Valves
- Pressure Vessels
- 2507
- Zeron 100

## RECOMMENDED FLUXES

P2000

## DIAMETERS / PACKAGING

Diameter in (mm)	55 lb (25 kg) Steel Spool
3/32 (2.4)	ED035156
1/8 (3.2)	ED035157

## WIRE COMPOSITION<sup>(1)</sup> – As Required per AWS A5.9

	%C	%Cr	%Ni	%Mo	%Mn	%Si
<b>Requirements</b> AWS ER2594	0.03 max	24.0 - 27.0	8.0 - 10.5	2.5 - 4.5	2.5 max	1.0 max
<b>Typical Results<sup>(2)</sup></b>	0.02	24.6	8.6	3.8	0.8	0.3
	%P	%S	%N	%Cu	%W	FN
<b>Requirements</b> AWS ER2594	0.03 max	0.02 max	0.20 - 0.30	1.5 max	1.00 max	Not Required
<b>Typical Results<sup>(2)</sup></b>	0.02	0.01	0.25	0.01	0.01	30 - 60

## TYPICAL OPERATING PROCEDURES

Process	Diameter in (mm)	Voltage (volts)	Amperage	Flux
SAW	3/32 (2.4)	28-33	275-350	Lincolnweld® P2000
	1/8 (3.2)	29-32	350-450	

<sup>(1)</sup>Typical all weld metal. <sup>(2)</sup>See test results disclaimer

IMPORTANT: SPECIAL VENTILATION AND/OR EXHAUST REQUIRED

Fumes from the normal use of some welding products can contain significant quantities of components - such as chromium and manganese - which can lower the 5.0 mg/m<sup>3</sup> maximum exposure guideline for general welding fume.

BEFORE USE, READ AND UNDERSTAND THE SAFETY DATA SHEET (SDS) FOR THIS PRODUCT AND SPECIFIC INFORMATION PRINTED ON THE PRODUCT CONTAINER.