

# SW-2594 Cored

Type : Rutile

## Conformances

AWS A5.22/ASME SFA 5.22 E2594T1-1/-4

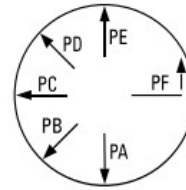
## Applications

- Welding of Super Duplex stainless steel(NAS 329J4L, UNS S32750)

## Features

- Good porosity resistance
- Good performance in all positions

## Welding Position



## Current

DC +

## Shielding Gas

100% CO<sub>2</sub>  
Ar+20% CO<sub>2</sub>

## Typical Chemical Composition of All-Weld Metal (%)

	C	Si	Mn	P	S	Cr	Ni	Mo	N	PREN
100% CO <sub>2</sub>	0.023	0.42	0.74	0.018	0.002	25.5	9.15	3.74	0.24	41.8
80% Ar + 20% CO <sub>2</sub>	0.031	0.52	0.75	0.012	0.001	25.7	9.11	3.78	0.23	41.9

## Typical Mechanical Properties of All-Weld Metal

	TS MPa(lbs/in <sup>2</sup> )	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft-lbs)
100% CO <sub>2</sub>	896 (129,920)	24.2	-20 (-4)	27 (19.9)
80% Ar + 20% CO <sub>2</sub>	891 (129,195)	26	-20 (-4)	37 (27.3)

## Typical Welding Parameters

Diameter, Polarity Shielding Gas	CTWD mm (in)	Wire Feed Speed m/min (in/min)	Amp. (A)	Volt. (V)	Deposition Rate kg/hr (lb/hr)
1.2mm (0.045 in) DC+					
100% CO <sub>2</sub>	20 (4/5)	6.2 (244)	140	23-26	2.6 (5.7)
		9.0 (354)	180	27-30	3.8 (8.4)
		12.0 (472)	210	28-31	4.6 (10.1)
80% Ar + 20% CO <sub>2</sub>	20 (4/5)	6.2 (244)	140	23-26	2.7 (5.9)
		9.0 (354)	180	27-30	3.7 (8.3)
		12.0 (472)	210	27-30	4.8 (10.6)

Diam.	15 kg Spool
1.2mm	HKSW259412

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