

# NOUVE<sup>®</sup> 2594-16

Designation

**AWS A5.4 E2594**  
**UNS No. W39594**

Welding Positions



## Features

- Excellent arc characteristics
- Low moisture re-absorption
- Low spatter level
- Low smoke level
- Quick & easy slag removal
- Radiography quality

## Applications

1. Used extensively in welding of duplex and super duplex stainless steels, which contains < 25% Cr.
2. Oil & gas industries 3. Petrochemical plants 4. Off shore plat forms 5. Marine & paper environments.

## Recommended Welding Techniques

- GENERAL : Electrode positive, work negative (DCEP)  
 ARC LENGTH : Short arc  
 STORAGE : Re-dry electrodes 250°C to 300°C for 1 hour before use.

## Weld Metal Chemistry

	Carbon	Chromium	Nickel	Molybdenum	Nb+Ta	Manganese	Silicon	Phosphorous	Sulphur	Copper
AWS	0.04	24-27	8-10.5	3.5-4.5	-	0.5-2.0	0.5-2.0	0.04	0.03	0.75
Typical	0.028	25.80	9.80	4.04	-	1.56	0.78	0.032	0.024	0.66

## Mechanical Properties (as welded)

MECHANICAL TESTS	Tensile Strength	Elongation % in 2"
AWS SPEC	760	15
TYPICAL	800	23