

Super duplex stainless and heat resistant steels

STARBLAZE PRIME 2594

Classification **AWS A5.4** : E2594-16 **DIN EN ISO 3581-A** : E 25 9 4 N LR 12 **Werkstoff Nr:** 1.4463

Description and applications Rutile-basic 25-10-4-N type non synthetic electrode for the welding of type 2507 super duplex stainless steels UNS S32750 (wrought) and UNS J93404 (cast) and similar compositions. Excellent resistant to pitting and crevice corrosion (PREN >40). Low carbon content, excellent weldability, spatter free arc, very smooth bead appearance. Weld metal has very high ferrite content in the range of 40-70FN. Packed in vacuum pack system.

Base Materials SAF 2507; UNS S32750; UNS J93404; ASTM A 182 F53; Uranus 47N, Material No. 1.4410, 1.4460, 1.4462, 1.4463

Typical weld metal Chemical Composition (%)

C	Mn	Si	Cr	Ni	Mo	P	S	N
0.03	1.20	0.50	25.00	9.50	4.00	0.015	0.010	0.25

All weld metal Mechanical properties (Typical)

Yield strength R_p (N/mm ²)	Tensile strength R_m (N/mm ²)	Elongation A_5 (%)	Charpy Impact value ISO-V J RT
≥ 650	≥ 800	≥ 20	≥ 50

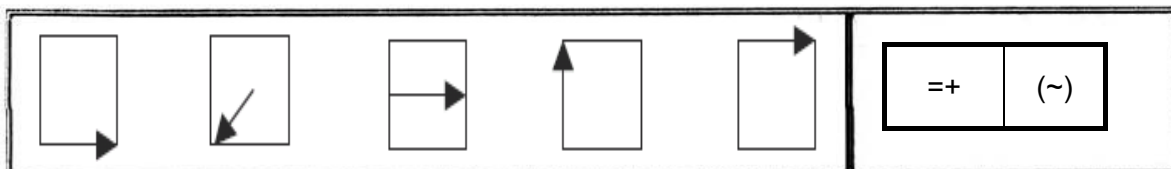
Amperes (A)

Dia (mm)	2.50mm	3.15mm	4.00mm	5.00mm
Amperage (A)	50 - 80	70 - 110	100- 150	140- 190

Welding Instruction

Keep dry and avoid condensation.
Re-dry electrode at 300°C for 1 hour if necessary, 3 times max.

Welding positions



Stellaris Specialities India Ltd.

(Division: StarBlaze India)

GST No.: 06AAICS2482B1ZK / Legal Metrology No.: GOI/DL/2022/4850

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Plant 3: B-100, Mayapuri Industrial Area, Phase-1, Near Police Station, New Delhi-110064

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