



### Characteristics:

LKT-2594 is super duplex stainless steel tig rod that have a nominal composition of 25%Cr - 9%Ni - 4%Mo - 0.25% N. Normally use to weld materials in the chemical and fertilizer industries, energy generation, flue gas desulfurization, and for many offshore applications including piping systems, pumps, valves, and heat exchangers. This filler metal provides high tensile and yield strengths and superior resistance to SCC and pitting corrosion.

### Applications:

It is designed for welding duplex (2500 family) and super duplex (wrought 2507 and Zeron 100, UNS S32750, S32760 and cast ASTM A890, UNS J93380, J93404).

### Notes on Usage:

1. For TIG process, use DC(-) current . 100 %Ar shielding gas.
2. Pre-heat is dosen't required.

### Typical chemical composition of weld metal (wt%)

C	Mn	Si	Cr	Ni	Mo	N	Cu
0.01	0.60	0.40	25.1	9.20	3.90	0.27	0.05

### Typical mechanical properties of weld metal

TS N/mm <sup>2</sup>	TS N/mm <sup>2</sup>	EL %
850	850	28

### Sizes and recommended current range <DC - >

Diameter (mm)	1.6	2.4	3.2
Amps	100-350	150-400	200-500
Travel Speed (cpm)	30	30	30