

2507

CLASSIFICATION

AWS A5.9M	ER2594
EN ISO 14343-A	W 25 9 4 N L

SHIELDING GASES (ACC. EN ISO 14175)

I1	Inert gas Ar (100%)
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CHEMICAL COMPOSITION (WEIGHT %), WIRE

	C	Mn	Si	S	P	Cr	Ni	Mo	W	Cu	N	PREN
Min.						24.0	8.0	3.0			0.20	40
Max.	0.03	2.5	1.0	0.02	0.03	27.0	10.5	4.5	0.5	0.5	0.30	
Typical	0.02	0.8	0.4	0.005	0.02	25	9.3	3.9	0.05	0.05	0.25	42

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

As welded	Min.	Typical
Tensile strength (MPa)	760	870
0.2% Proof strength (MPa)	550	695
Elongation (%) 4d	15	36
	5d	32
Reduction of area (%)		68
Impact ISO-V (J) - 50°C		130
Hardness, cap/mid (HV)		300

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Weight (kg)	Item number
1.6	PE Tube	2.5	T2507-16
2.4	PE Tube	2.5	T2507-24

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.eu for any updated information.