

LNM 2507

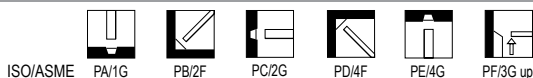
CLASSIFICATION

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

GENERAL DESCRIPTION

The Superduplex 2507 is used when good corrosion resistance, stress corrosion cracking and pitting corrosion are a concern. It is used for welding austenitic-ferritic stainless alloys of the 25%Cr 7%Ni 4%Mo low-C types.

WELDING POSITIONS



SHIELDING GASES (ACC. ISO 14175)

M12 Mixed gas Ar+ 0.5-5% CO₂
M13 Mixed gas Ar+ 0.5-3% O₂

CHEMICAL COMPOSITION (W%) TYPICAL WIRE

C	Mn	Si	Cr	Ni	Mo	Cu	Nb	P	S	V	W	N
0.03	2.5	1.0	24.0-27.0	8.0-10.5	2.5-4.5	0.05	0.03	0.03	0.02	0.1	1.0	0.20-0.30

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J) -40°C
Typical values	M12	AW	650	850	23	55

MATERIALS TO BE WELDED

Steel grades	ASTM	UNS
25%Cr Superduplex	A182 F53, F55 BS EN 10088-2 X2CrNiMoN25-7-4 (1.4410) SAF 2507(Sandvik/Avesta) Uranus 47N(CLI)	S32750, S32760
Casting	A890 Gr5A, 6A ACI CE3MN	J93404

APPLICATION ADVICE

Offshore Oil/Gas, chemical and petrochemical process industries, pipework systems, flowlines, paper industry, manifolds, etc.
Preheat is not generally required. Interpass temperature 150° max is recommended. Heat input in the range 1.0-2.0KJ/mm, depending on material thickness should be acceptable but most codes restrict the max to 1.5 or 1.75KJ/mm.

PACKAGING AND AVAILABLE SIZES

Diameter (mm)	1.0	1.2
Unit : 15 kg spool B300	X	X

Other sizes and packaging on request

LNM 2507: rev. EN 01