

2507XKS

TOP FEATURES

- Basic coated all-positional stick electrode for welding superduplex alloys for service in the as-welded condition
- Especially developed for steels difficult to weld, such as armour plates, austenitic Mn-steels and high C-steels
- Excellent weldability and self releasing slag
- Weldable on AC and DC+ polarity
- Recovery about 100%

TYPICAL APPLICATIONS

- Offshore oil/gas, chemical and petrochemical process industries

CLASSIFICATION

AWS A5.4	E2594-15
EN ISO 3581-A	E 25 9 4 N L B 4 2

CURRENT TYPE

DC+

WELDING POSITIONS

All position, except vertical down

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	N	PREN
Min.	not specified	0.5	not specified	not specified	not specified	24.0	8.5	3.5	not specified	0.20	40
Max.	0.04	2.0	1.0	0.02	0.03	26.0	10.5	4.5	0.5	0.30	46
Typical	0.03	1	0.5	0.01	0.02	25	9.5	3.8	0.1	0.22	42

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

As welded		Min.	Typical	>1120°C/>3h + WQ transverse *
Tensile strength	(MPa)	800	870	>760
0.2% Proof strength	(MPa)	550	700	-
Elongation (%)	4d	22	28	-
	5d	18	25	-
Reduction of area (%)		not specified	45	-
Impact ISO-V (J)	+20°C	not specified	85	-
	-50°C	not specified	60	>80
	-75°C	not specified	35	-
Hardness (HV)		not specified	280-330	<300

*Representative properties for solution treated welds in castings of ASTM A890 grade 5A. Ferrite >30%.

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
3.2 x 350	70-95
4.0 x 350	100-155

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
3.2 x 350	VPMD	60	2.0	2507XKS-32-2
4.0 x 350	VPMD	40	2.0	2507XKS-40-2

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.