



## Characteristics

Grade 2507 is a Molybdenum and Nitrogen alloyed Super-Duplex stainless steel with corrosion resistance in-line with the 6 Mo grades (eg. 254 SMO®), and with a yield strength more than double that of austenitic stainless steels. It is also the strongest Duplex in welded tubular products.

### Characteristic properties:

- High mechanical strength
- Good weldability
- Good corrosion resistance
- High resistance to Stress Corrosion Cracking (SCC)
- Good machinability
- Very good wear and abrasive resistance
- Low thermal expansion
- Good fatigue properties
- Temperature range -40°C to 250°C

## Dimensions

Tubular products in grade 2507 are not stock standard, but can be manufactured in most common standard sizes within Outokumpu Stainless Tubular Products product range.

### Pipe

- OD: 17.2-1219.0 mm
- WT: 1.5-25.4 mm
- Lengths: up to 12 m

### Heat exchanger tubes

- OD: 12.0-114.3 mm
- WT: 0.6-4.0 mm
- Lengths: up to 15 m

## Executions

### Tubes, Pipes and Butt Weld Fittings

- Welded with- or without filler metal
- Unannealed, pickled
- Solution annealed and pickled
- With- or without BCW (Bead Cold Worked)
- Bevelled ends according to standards

### Heat exchanger tubes

- No BCW for laser welded tubes, h max = 0.15 mm
- Tig welded tubes are BCW
- Solution annealed and pickled

## Corrosion resistance

Grade 2507 possesses excellent resistance to general corrosion, SCC, pitting corrosion and high resistance to crevice corrosion. It has similar resistance to sea water as the 6 Mo grades, and has hence been widely used in sea water RO desalination. See Outokumpu Corrosion Handbook for more information.

## Microstructure / Ferrite content

The balanced chemical composition of 2507 results in a microstructure containing approximately equal amount of ferrite and austenite in the microstructure after annealing in a temperature about 1050-1125°C. By determining the ferrite content in the weld, it is ensured that the welding and/or annealing has been done properly. The general opinion is that a too high ferrite content, i.e. > 70 % decreases the toughness and pitting resistance, and a too low ferrite content, i.e. < 25 % decreases the SCC-resistance.

## Product standards

### Europe

- EN 10296-2 Welded SS tubes for general purposes
- EN 10217-7 Welded SS tubes for pressure purposes
- EN 10253-3: Butt-welding pipe fittings. Wrought austenitic and austenitic-ferritic (Duplex) stainless steels without specific inspection requirements.
- EN 10253-4 Butt-welding pipe fittings. Wrought austenitic and austenitic-ferritic (Duplex) stainless steels with specific inspection requirements.

### USA

- ASTM A 789 Welded and seamless F/A SS heat exchanger tubes.
- ASTM A 790 Welded and seamless F/A SS pipe.
- ASTM A 928 F/A SS pipe fusion welded with filler metal.
- ASTM A 815 Wrought Ferritic, Duplex, martensitic stainless steel piping fittings.

## Weld factor

Type of weld process and NDT	EN 13480-3		ASME B31			
	EN 10217-7 / EN 10253-4	EN 10296-2 / EN 10253-3	A 789	A 790	A 798	A 928
EFW, 100 % ET	1.0	-	0.8	0.8	0.8	0.8
EFW, 100 % RT	1.0	-	1.0	1.0	1.0	1.0
EFW, spot RT	-	0.85	-	-	-	0.9
EFW, double butt	-	0.7	0.85	0.85	0.85	0.85
EFW, single butt	-	0.7	0.8	0.8	0.8	-

EFW = Electric Fusion Welded      ET = Eddy Current Test      RT = Radiographic Test

The joint coefficient (z used in EN standards) or Joint quality factor (Ej, used in ASME standards) is used for calculation of the wall thickness for welded tubes. The type of welding process, amount and type of NDT decide the factor.

## Chemical composition, % (Typical values)

Outokumpu	EN	ASME/UNS	C	Cr	Ni	Mo	N	Others	PRE*
4307	1.4307	304L	0.02	18.1	8.1	-	-	-	18
4404	1.4404	316L	0.02	17.2	10.1	2.1	-	-	24
LDX 2101®	1.4162	S32101	0.03	21.5	1.5	0.3	0.22	5Mn	26
2304	1.4362	S32304	0.02	23	4.8	0.3	0.10	-	26
2205	1.4462	S32205**	0.02	22	5.7	3.1	0.17	-	35
<b>2507</b>	<b>1.4410</b>	<b>S32750</b>	<b>0.02</b>	<b>25</b>	<b>7</b>	<b>4</b>	<b>0.27</b>	-	<b>43</b>

\* PRE = % Cr + 3.3 % Mo + 16 % N (The formula is used as a ranking tool to estimate pitting corrosion resistance in the material).

\*\* Also available as S31803.

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## Pressure vessel approvals

### Europe

The Pressure Equipment Directive PED regulates the use of welded SS pipe in most European countries. Outokumpu Stainless Tubular Products fulfils the Directive, and is an approved manufacturer of welded Duplex stainless steel tubes and fittings.

### Outside Europe

Pressure vessel regulations are authorized to ASME. ASME Section II, Part D Table 2A, shows design values for tube and pipe. ASME B31.1 Power Piping and ASME B31.3 Process Piping state design for approved pipe material.

### Norway

NORSOK is a Norwegian standard that regulates the use of materials in some offshore applications. Outokumpu Stainless Tubular Products is an approved manufacturer of Duplex UNS S32750 pipe and fittings based on NORSOK requirements.

## Fabrication

### Welding

Common welding methods for tubular products are:

- MMA, SMAW (Shielded Metal Arc Welding)
- TIG, GTAW (Gas Tungsten Arc Welding)
- MIG, MAG, GMAW (Gas Metal Arc Welding)
- FCAW (Flux-Cored Arc Welding)
- PAW (Plasma Arc Welding)
- SAW (Submerged Arc Welding)

The general recommendation for shield and plasma gas is pure Argon (TIG/PAW). An addition of 1-2% nitrogen in the shielding gas for TIG and PAW methods will improve the pitting corrosion resistance in the weld. As backing/purging gas the general recommendation is pure Argon or Formier gas (90 % N<sub>2</sub> and 10 % H<sub>2</sub>).

General filler recommendation for steel grade 2507 can be found in the table above.

Welding without filler metal not followed by post heat treatment will reduce the corrosion resistance and is therefore not recommended.

See Outokumpu Welding Handbook for more information.

## Applications

- Chloride containing environments
- Heat exchanger tubes
- Pipe systems within
  - Hydrometallurgy
  - Chemical and Petrochemical
  - Desalination
  - Oil & Gas

## Design

The allowable design values are more than twice than for standard austenitic steels. This means that the possibility of designing thinner walls can save costs. Please use our Press Calculation Tool on [www.outokumpu.com](http://www.outokumpu.com), to discover the weight saving possibilities and other benefits of Outokumpu Duralite™ Duplex Stainless Steel.

### Cold forming

Since the yield strength is more than twice that of standard austenitic grades, a higher initial force is necessary in operations such as bending or expanding tubes into tube sheets. The spring back effect is also more pronounced.

### Heat treatment

Normal annealing temperature is 1050-1125°C followed by rapid cooling to at least 700°C. At temperatures between 800-950°C, intermetallic phases that impair the properties will form within 1-2 minutes.

## General filler recommendation for Duplex stainless steels

Outokumpu	EN	ASTM / UNS	Welding consumables	
			Covered electrodes ISO 3581 / ISO 14172	Wires ISO 14343 / ISO 18274
LDX 2101®	1.4162	S32101	23 7 NL or 22 9 3 NL	23 7 NL or 22 9 3 NL
2304	1.4362	S32304	23 7 NL or 22 9 3 NL	23 7 NL or 22 9 3 NL
2205	1.4462	S2205 / S31803	22 9 3 NL	22 9 3 NL
<b>2507</b>	<b>1.4410</b>	<b>S32750</b>	<b>25 9 4 NL</b>	<b>25 9 4 NL</b>

## Mechanical properties (At room temperature)

Outokumpu	Min values acc. to EN 10028-7:2007									Min values according to ASTM A240-07		
	R <sub>p0.2</sub> ' MPa			R <sub>m</sub> ' MPa			A <sub>80</sub> ' %			R <sub>p0.2</sub> ' MPa	R <sub>m</sub> ' MPa	A <sub>5</sub> ' %
	P	H	C	P	H	C	P	H	C			
4307	200	200	220	500	520	520	45	45	45	170	485	40
4404	220	220	240	520	530	530	45	40	40	170	485	40
LDX 2101®	450*	480*	530*	650*	680*	700*	30*	30*	20*	530 (t ≤ 5.0 mm) / 450 (t > 5.0 mm)	700 (t ≤ 5.0 mm) / 650 (t > 5.0 mm)	30
2304	385/400	385/400	405/420	630	600	600	25	20	20	400	600	25
2205	445/460	445/460	485/500	640	700	700	25	25	20	450	655	25
<b>2507</b>	<b>515/530</b>	<b>515/530</b>	<b>535/550</b>	<b>730</b>	<b>750</b>	<b>750</b>	<b>20</b>	<b>20</b>	<b>20</b>	<b>550</b>	<b>795</b>	<b>15</b>

\* Min values according to EN 10088-4:2009

P = Hot rolled plate

H = Hot rolled strip

C = Cold rolled coil and strip

## Physical properties

Outokumpu	Density, g/cm <sup>3</sup>	Modulus of elasticity, GPa	Poisson's ratio $\nu = -\epsilon_{trans} / \epsilon_{longitudinal}$	Average linear expansion at RT -
				100°C x 10 <sup>-6</sup> / °C
4307	7.9	200	0.3	16.0
4404	8.0	200	0.3	16.0
LDX 2101®	7.8	200	0.3	13.0
2304	7.8	200	0.3	13.0
2205	7.8	200	0.3	13.0
<b>2507</b>	<b>7.8</b>	<b>200</b>	<b>0.3</b>	<b>13.0</b>

## Activating Your Ideas

Outokumpu is a global leader in stainless steel with the vision to be the undisputed number one. Customers in a wide range of industries use our stainless steel and services worldwide. Being fully recyclable, maintenance-free, as well as very strong and durable material, stainless steel is one of the key building blocks for sustainable future.

What makes Outokumpu special is total customer focus – all the way, from R&D to delivery. You have the idea. We offer world-class stainless steel, technical know-how and support. We activate your ideas.

[www.outokumpu.com](http://www.outokumpu.com)