Cromarod 2507B

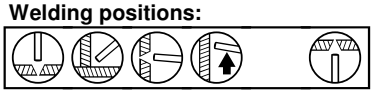
SMAW - (Stick) - MMA

Stainless Steel

Date: 2009-02-27
Revision: 18

Description:
Cromarod 2507B is a basic flux coated electrode which deposits a 25%Cr / 9.0%Ni / 4.0%Mo / 0.25%N super dupex type stainless steel weld with a ferrite content of approximately FN 40. It is designed to give very good fracture toughness at temperatures down to -40 °C. The electrode is intended for welding similar composition steels e.g. SAF 2507, Uranus 52N, Zeron 100, which offer even higher strength and corrosion resistance levels than the ordinary duplex grades. A heat input range of 0.4-1.5 KJ/mm is recommended to maintain a favourable phase balance in the weld metal and avoid unfavourable precipitation effects in the plate. Applications include offshore platform pipework for seawater cooling systems and firefighting water, as well as pumps, valves and risers.

Welding positions:



Coating type:
Basic

Welding current:
DC+

Ferrite content:
FN 40 (WRC -92)

Corrosion resistance
Very good resistance to pitting corrosion and stress corrosion cracking in chloride and H2S environments. Good resistance to intergranular corrosion.
Pitting resistance equivalent, PRE = 41.
Critical pitting temperature CPT = 40°C (ASTM G48).

Scaling temperature:
Approx. 850°C in air.

Redrying temperature:
350 °C, 2h

Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min			0,7			24,0	8,0
Typical	0,03	0,4	0,85	0,02	0,02	25,0	8,5
Max	0,04	0,6	1,0	0,030	0,025	27,0	10.0

	Mo	Cu	V	Nb	N
Min	3,5				0,20
Typical	3,7				0,23
Max	4,5	0,5	0,1	0,1	0,30

Mechanical properties

	Specified	Typical
Yield strength, Rp0.2%:	≥ 550 MPa	750 MPa
Tensile Strength, Rm:	≥ 760 MPa	900 MPa
Elongation, A5	≥ 18%	24%
Impact energy, CV:		-40 °C • 55 J

Classification:

EN 1600	E 25 9 4 N L B 12
AWS A5.4	E2594-15
ISO 3581-A	E 25 9 4 N L B 12

Approvals:
CE

Note

Core wire:
P ≤ 0.020%
S ≤ 0.010%
0.14% ≤ N ≤ 0.17%

Produkt data:

Diam.mm	Length mm	Product code	Current A	Voltage V	Kg weld metal/ kg electrodes	No. of electrodes/ kg weld metal	Kg weld metal/ hour arc time	Burn-off time/ electrode (sec.)
2,5	300	74572500	60-90	23	0,71	79	1,0	39
3,2	350	74573200	80-120	24	0,71	41	1,4	55
4,0	350	74574000	130-170	26	0,73	26	2,0	60