



SAF 2507[®]

BAR

DATASHEET

SAF 2507[®] is a high alloy duplex (austenitic-ferritic) stainless steel for service in highly corrosive conditions. The grade is characterized by:

- Excellent resistance to stress corrosion cracking in chloride-bearing environments
- Excellent resistance to pitting and crevice corrosion
- High resistance to general corrosion
- Very high mechanical strength
- Physical properties that offer design advantages
- High resistance to erosion corrosion and corrosion fatigue good weldability
- Excellent mechanical properties that allow for lighter constructions, more compact design and less welding

STANDARDS

- UNS: S32750
- EN Number: 1.4410
- EN Name: X2CrNiMoN25-7-4

Product standards

- EN 10088-3, (dimensions up to 160 mm)
- EN 10272, EN 10222-5
- ASTM A479, ASTM A276
- NORSOK MDS D57 Rev 4, Rev 5
- Suitable for manufacturing of components in accordance with ASTM A182

Approvals

- Pressure Equipment Directive (2014/68/EU)
- NORSOK M650 Ed. 4, NORSOK M630 Ed. 6, dimensions up to 250 mm.
- DNV, dimensions up to 250 mm
- Pre-approval for PMA

Certificate

Status according to EN 10 204/3.1

CHEMICAL COMPOSITION (NOMINAL)

Chemical composition (nominal) %

C	Si	Mn	P	S	Cr	Ni	Mo	N	Cu
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Chemical composition (nominal) %

C	Si	Mn	P	S	Cr	Ni	Mo	N	Cu
≤0.030	≤0.8	≤1.2	≤0.035	≤0.015	25	7	4	0.3	≤0.5

APPLICATIONS

SAF 2507® is a duplex stainless steel specially designed for service in aggressive chloride-containing environments. Typical applications are:

- Oil and gas industry
- Seawater cooling
- Salt evaporation industry
- Desalination plants
- Geothermal wells
- Refineries and petrochemical plants
- Mechanical components requiring high strength
- Pulp and paper industry

CORROSION RESISTANCE

General corrosion

SAF 2507® is highly resistant to corrosion by organic acids, e.g. formic and acetic acid. It is suitable for use at high concentrations and temperatures, where austenitic stainless steels corrode at a high rate.

Resistance to inorganic acids is comparable to that of high alloy austenitic stainless steels in certain concentration ranges.

Pitting and crevice corrosion

The pitting and crevice corrosion resistance of a stainless steel is primarily determined by the content of chromium, molybdenum and nitrogen. An index for comparing the resistance to pitting and crevice corrosion is the PRE number (Pitting Resistance Equivalent).

The PRE is defined as, in weight-% $PRE = \%Cr + 3.3 \times \%Mo + 16 \times \%N$

For duplex stainless steels the pitting corrosion resistance is dependent on the PRE-value in both the ferrite phase and the austenite phase, so that the phase with the lowest PRE-value will be limiting for the actual pitting corrosion resistance. In SAF 2507® the PRE-value is equal in both phases, which has been achieved by a careful balancing of the elements.

The minimum PRE-value for SAF 2507® is 41. This is significantly higher than e.g. the PRE-values for other duplex stainless steels of the 25Cr type which are not "super-duplex". As an example UNS S31260 (25Cr3Mo0.2N) has a PRE-value of typically 38.

One of the most severe pitting and crevice corrosion tests applied to stainless steel is ASTM G48, i.e., exposure to 6% FeCl₃ with and without crevices (method A and B respectively). When pits are detected following a 24 hours exposure, together with a substantial weight loss (>5 mg), the test is interrupted. Otherwise, the temperature is increased 5°C (9°F) and the test is continued with the same sample. Figure 4 shows critical pitting and crevice temperatures (CPT and CCT) from this test.

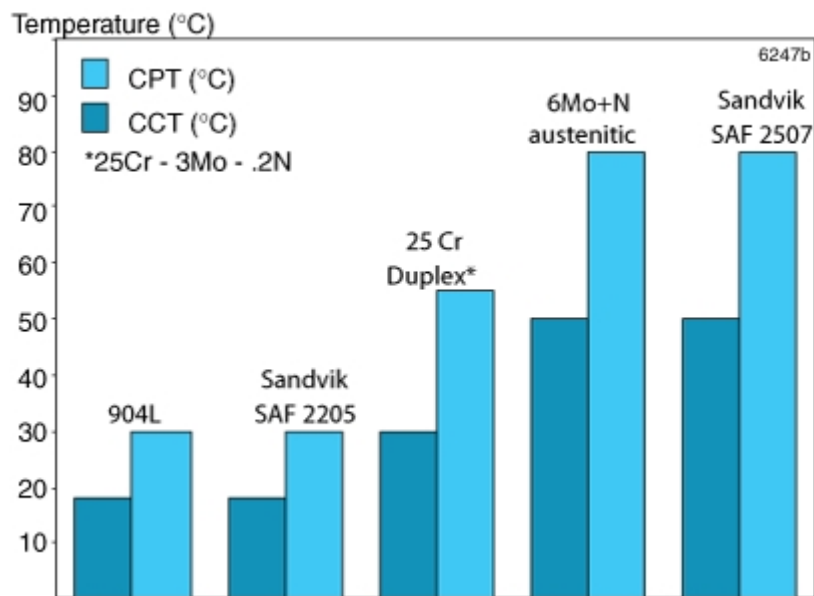


Figure 4. Critical pitting and crevice temperatures in 6% FeCl₃. 24h (similar to ASTM G48).

Stress corrosion cracking

SAF 2507® has excellent resistance to chloride-induced stress corrosion cracking.

Erosion corrosion and corrosion fatigue

The superior mechanical properties combined with the improved corrosion resistance of SAF 2507® result in excellent resistance to both erosion corrosion and corrosion fatigue compared to standard austenitic stainless steels.

FORMS OF SUPPLY

Finishes and dimensions

SAF 2507® bar steel is stocked in a large number of sizes. The standard size range for stock comprises 20-250 mm, see pocket card S-02909. Round bar is supplied in solution annealed and water quenched condition. The surface is peeled turned and polished.

Lengths

Bars are delivered in random lengths of 3-7 m, depending on diameter.

Straightness

Diameter mm	Height of arch, mm/m Typical value
20 - 70	1
> 70	2

Tolerances, mm-sizes

Diameter, mm	Tolerances, mm
20-35	-0/+0.15
40-45	-0/+0.16
50-70	-0/+0.19
75-95	-0/+1.00

Diameter, mm	Tolerances, mm
100-250	-0/+1.50

Surface conditions

Surface conditions	Ra, μm Typical value	Size, mm dia
Peeled and burnished	1	20-250

HEAT TREATMENT

Bars are normally delivered in solution annealed and quenched condition. Additional heat treatment, as recommended below is only needed if further hot working has been made.

Solution annealing

Slow heating up to 1000°C (1830°F). Annealing at 1050-1125°C (1920-2060°F), followed by quenching.

MECHANICAL PROPERTIES

Bar steel is tested in delivery condition.

The following figures apply to material in the solution annealed and quenched condition.

For small sections the proof strength values are higher than those listed below at 20 °C (68 °F).

More detailed information can be supplied on request.

At 20°C (68°F)

Metric units, bar

Proof strength	Tensile strength	Elong.	HB
R _{p0.2} ^{a)}	R _m	A ^{b)}	
MPa	MPa	%	
			approx.
≥550	760-930 ^{c)}	≥25	260

Imperial units, bar

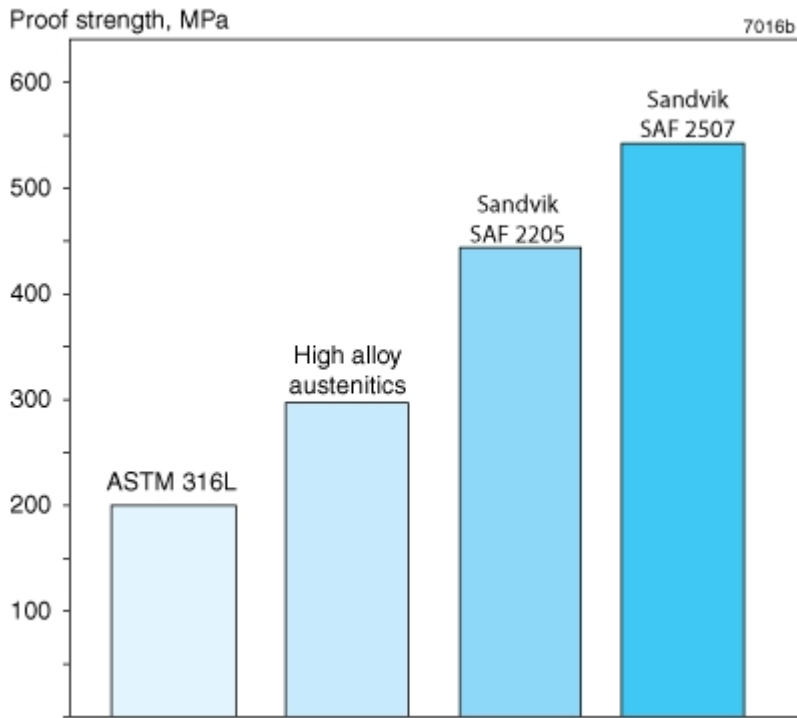
Proof strength	Tensile strength	Elong.	Hardness
R _{p0.2} ^{a)}	R _m	A ^{b)}	Rockwell C
ksi	ksi	%	
≥80	110-135	≥25	≤28

1 MPa = 1 N/mm²

^{a)} R_{p0.2} corresponds to 0.2% offset yield strength.

^{b)} Based on $L_0 = 5.65\sqrt{S_0}$, where L_0 is the original gauge length and S_0 the original cross-section area.

^{c)} For sizes below 50 mm/2" R_m min. 800 MPa.



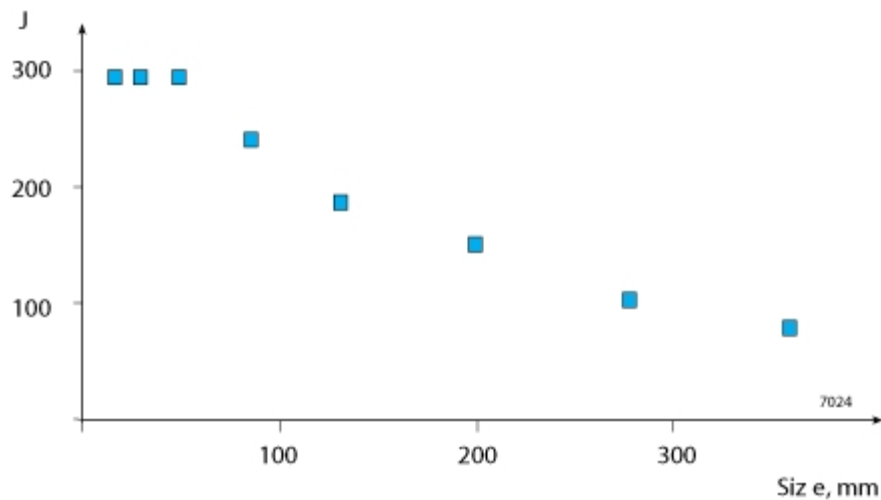
At higher temperatures

If SAF 2507® is exposed for prolonged periods to temperatures exceeding 250°C (480°F), the microstructure changes which results in a reduction in impact strength. This effect does not necessarily affect the behavior of the material at the operating temperature.

More detailed information can be supplied on request.

Impact strength

SAF 2507® possesses good impact strength. Figure 2 shows typical impact energy values for SAF 2507® in different sizes at -20°C (-4°F), using standard Charpy V specimens. Samples taken in the longitudinal direction.



The impact energy (Charpy V) at 20°C (68°F) is min 100 J (74 ft-lb).

PHYSICAL PROPERTIES

Density: 7.8 g/cm³, 0.28 lb/in³

Specific heat capacity

Metric units, Imperial units

Temperature, °C	J/(kg °C)	Temperature, °F	Btu/(lb °F)
20	490	68	0.12
100	505	200	0.12
200	520	400	0.12
300	550	600	0.13
400	585	800	0.14

Thermal conductivity

Metric units, W/(m °C)

Temperature, °C	20	100	200	300	400
SAF 2507	14	15	17	18	20
AISI 316L	14	15	17	18	20

Imperial units, Btu/(ft h °F)

Temperature, °F	68	200	400	600	800
SAF 2507	8	9	10	11	12
AISI 316L	8	9	10	10	12

Thermal expansion

SAF 2507® has a coefficient of thermal expansion close to that of carbon steel. This gives SAF 2507® definite design advantages over austenitic stainless steels in equipment comprising of both carbon steel and stainless steel. The values given below are average values in the temperature ranges.

Metric units, x10⁻⁶/°C

Temperature, °C	30-100	30-200	30-300	30-400
SAF 2507	13.5	14.0	14.0	14.5
Carbon Steel	12.5	13.0	13.5	14.0
ASTM 316L	16.5	17.0	17.5	18

Imperial units, x10⁻⁶/°F

Temperature, °F	86-200	86-400	86-600	86-800
SAF 2507	7.5	7.5	8.0	8.0
Carbon Steel	6.8	7.0	7.5	7.8
ASTM 316L	9.0	9.5	10.0	10.0

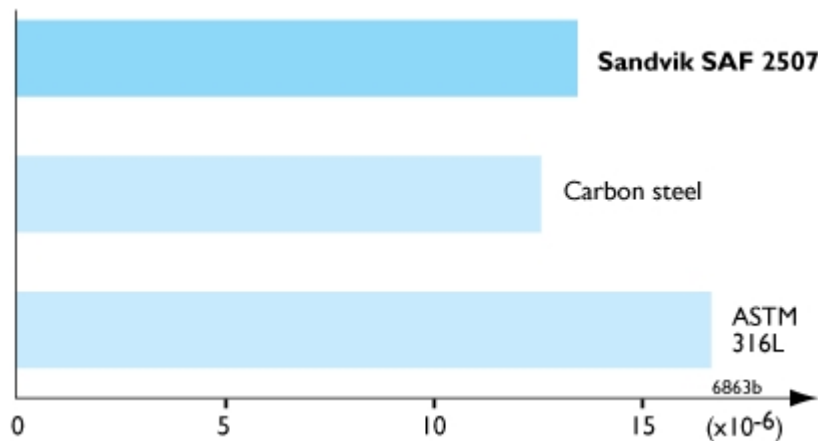


Figure 3. Thermal expansion, per °C (30-100°C, 86-210°F).

Resistivity

Temperature, °C	μΩm	Temperature, °F	μΩin.
20	0.83	68	32.7
100	0.89	200	34.9
200	0.96	400	37.9
300	1.03	600	40.7
400	1.08	800	43.2

Modulus of elasticity, (x10³)

Metric units Imperial units

Temperature, °C	MPa	Temperature, °F	ksi
20	200	68	29.0
100	194	200	28.2
200	186	400	27.0
300	180	600	26.2

MACHINING

Being a two-phase material (austenitic-ferritic) SAF 2507® will present a different wear picture from that of single-phase steels of type ASTM 304L. The cutting speed must therefore be lower than that recommended for ASTM 304L. It is recommended that a tougher insert grade is used than when machining austenitic stainless steels, e.g. ASTM 304L. Also in comparison with SANMAC® 2205 lower speed and tougher insert grade is recommended. Machining recommendations available on request. More cutting data information for SAF 2507® is available in the product handbook S-02909-ENG, these recommendations could act as guidelines in choice of appropriate cutting data.

WELDING

The weldability of SAF 2507® is good. Suitable methods of fusion welding are manual metal-arc welding (MMA/SMAW) and gas-shielded arc welding, with the TIG/GTAW method as first choice.

For SAF 2507®, heat input of 0.2-1.5 kJ/mm and interpass temperature of <150°C (300°F) are recommended. Preheating and post-weld heat treatment are normally not necessary.

Recommended filler metals

GTAW/TIG welding

ISO 14343 S 25 9 4 N L / AWS A5.9 ER2594 (e.g. Exaton 25.10.4.L)

MMA/SMAW welding

ISO 3581 E 25 9 4 N L R / AWS A5.4 E2594-16 (e.g. Exaton 25.10.4.LR)

ISO 3581 E 25 9 4 N L B / AWS A5.4 E2594-15 (e.g. Exaton 25.10.4.LB)

Disclaimer: Recommendations are for guidance only, and the suitability of a material for a specific application can be confirmed only when we know the actual service conditions. Continuous development may necessitate changes in technical data without notice. This datasheet is only valid for Sandvik materials.