



## Cromatig 2507

### Classification:

EN ISO 14343  
AWS A5.9

W 25 9 4 N L  
ER2594

### Description:

Cromatig 2507 deposits a 25%Cr/10%Ni/4%Mo/0.25% N super duplex type weld metal with a ferrite level of approximately FN 55. It is designed 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. Cromatig 2507 may also be used for welding standard duplex steels when higher corrosion resistance in the weld metal is required. 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 deleterious precipitation effects in the plate. Applications include offshore platform pipework for seawater cooling systems and firefighting water, as well as pumps, valves and risers. The weld metal has excellent fracture toughness at temperatures down to -40°C.

### Welding current:

DC-

### Shielding gas:

I1, 99.99% Ar, 6-12 l/min

### Stamping

Elga, AWS, Wst, EN, Batch

### Wire composition, wt.%

C	Si	Mn	Cr	Ni	Mo	N
0,015	0,3	0,4	25	9,5	4,0	0,25

### Mechanical properties

#### Typical

Yield strength, Rp0.2%: 640 MPa  
Tensile Strength, Rm: 850 MPa  
Elongation, A5: 25%  
Impact energy, CV: 20°C • 135 J  
-40°C • 60 J

### Ferrite content:

FN 55

### Corrosion resistance

Very good resistance to pitting corrosion and stress corrosion cracking in chloride and H<sub>2</sub>S environments. Good resistance to intergranular corrosion. Pitting resistance equivalent, PRE = 42. Critical pitting temperature CPT = 40°C (ASTM G48).

### Scaling temperature:

Approx. 850°C in air.

### Product data:

Ø x Length mm	Packet weight
1,6 x 1000	5 kg
2,0 x 1000	5 kg
2,4 x 1000	5 kg