

SUPERCORE® 2507P

Stainless ▪ AWS E2594T1-4

KEY FEATURES

- Use on 25% Cr super duplex stainless
- Exceptional bead appearance
- High deposition rates
- Vacuum sealed pack
- High resistance to chloride induced stress corrosion cracking
- Q2 Lot® - Certificate showing deposit composition, ferrite number, and charpy impact properties tested at -196C(-320F)

WELDING POSITIONS

All

DIAMETERS / PACKAGING

Diameter mm (in)	15 kg (33.1 lb) Spool
1.2 (0.045)	ED033530, SC2507P-12*

*The Metrode part number will be replacing the current EDO numbers after the inventory has been depleted.

CONFORMANCES

AWS A5.22	E2594T1-4
EN ISO 17633-A:	T25 9 4 N L R M21 2

TYPICAL INDUSTRY SEGMENTS

- Duplex Stainless Steel Plates and Vessels
- Duplex Stainless Steel Pipe and Fittings

SHIELDING GAS

80% Argon / 20%CO₂

MECHANICAL PROPERTIES⁽¹⁾

	Yield Strength ⁽²⁾ MPa (ksi)	Tensile Strength MPa (ksi)	Elongation %	Charpy V-Notch J (ft-lbf)		
				@ 20°C (68°F)	@ -20°C (-40°F)	@ -50°C (-58°F)
Requirements AWS E2594T1-4	550 (80) min	760 (110) min	15 min	-	-	-
Typical Results As-Welded	660 (96)	870 (126)	30	60 (44)	45 (33)	35 (26)

DEPOSIT COMPOSITION⁽¹⁾

	%C	%Mn	%Si	%S	%P	%Cr
Requirements AWS E2594T1-4	0.04 max	0.5 - 2.0	1.00 max	0.02 max	0.03 max.	24.0 - 26.0
Typical Results⁽³⁾	0.03	1.0	0.50	0.01	0.02	24.5
	%Ni	%Mo	%Cu	%W	%N	PRE ⁽⁵⁾
Requirements AWS E2594T1-4	8.5 - 10.5	3.5 - 4.5	0.5 max	0.5 max	0.20 - 0.30	40 min
Typical Results⁽³⁾	9.3	3.8	0.05	0.05	0.23	41

TYPICAL OPERATING PROCEDURES

Diameter mm (in)	Amp-Volt Range	Typical	Stickout mm (in)
1.2 (0.045) DC+	120-250A, 22-32V	150A, 25V	0.59 - 0.78, (15-20)

⁽¹⁾Typical all weld metal. ⁽²⁾Measured with 0.2% offset. ⁽³⁾See test results disclaimer on pg. 13. ⁽⁴⁾Industry specific data, not required by AWS. ⁽⁵⁾PRE (pitting resistance equivalent) = Cr + 3.3Mo = 16N.
NOTE: Additional test data available upon request.

IMPORTANT: SPECIAL VENTILATION AND/OR EXHAUST REQUIRED

Fumes from the normal use of some welding products can contain significant quantities of components - such as chromium and manganese - which can lower the 5.0 mg/m³ maximum exposure guideline for general welding fume.

BEFORE USE, READ AND UNDERSTAND THE MATERIAL SAFETY DATA SHEET (MSDS) FOR THIS PRODUCT AND SPECIFIC INFORMATION PRINTED ON THE PRODUCT CONTAINER.

Material Safety Data Sheets (MSDS) and Certificates of Conformance are available on our website at www.lincolnelectric.com

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.

CUSTOMER ASSISTANCE POLICY

The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for information or advice about their use of our products. Our employees respond to inquiries to the best of their ability based on information provided to them by the customers and the knowledge they may have concerning the application. Our employees, however, are not in a position to verify the information provided or to evaluate the engineering requirements for the particular weldment. Accordingly, Lincoln Electric does not warrant or guarantee or assume any liability with respect to such information or advice. Moreover, the provision of such information or advice does not create, expand, or alter any warranty on our products. Any express or implied warranty that might arise from the information or advice, including any implied warranty of merchantability or any warranty of fitness for any customers' particular purpose is specifically disclaimed.

Lincoln Electric is a responsive manufacturer, but the selection and use of specific products sold by Lincoln Electric is solely within the control of, and remains the sole responsibility of the customer. Many variables beyond the control of Lincoln Electric affect the results obtained in applying these types of fabrication methods and service requirements.

Subject to Change – This information is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.com for any updated information.

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