

# Ultramet™ 2507

## TOP FEATURES

- Rutile coated MMA electrode for welding superduplex alloys for service in the as-welded condition
- Recovery is about 105%

## TYPICAL APPLICATIONS

- Offshore oil/gas, chemical and petrochemical process industries

## CLASSIFICATION

AWS A5.4 E2594-16  
EN ISO 3581-A E 25 9 4 N L R 3 2

## CURRENT TYPE

DC+/AC

## WELDING POSITIONS

All position, except vertical down

## CHEMICAL COMPOSITION (WEIGHT %), WELD METAL

C	Mn	Si	S	P	Cr	Ni	Mo	Cu	N	PREN
0.03	1.0	0.8	0.01	0.02	25	9.5	4	0.1	0.23	41

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

As welded	Required: AWS A5.4	EN ISO 3581-A	Typical
Tensile strength (MPa)	min. 760	min. 620	890
0.2% Proof strength (MPa)	not specified	min 550	750
Elongation (%) 4d	min. 15		26
5d		min. 18	24
Impact ISO-V (J) -20°C	not specified	not specified	35
-50°C	not specified	not specified	22
Hardness (HV)	not specified	not specified	275-315
(HRC)	not specified	not specified	28

## OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5x300	60-90
3.2x350	75-120
4.0x350	100-155

## PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 300	CAN	215	3.7	UM2507-25-1
3.2 x 350	CAN	117	4.2	UM2507-32-1
4.0 x 350	CAN	80	4.2	UM2507-40-1

## 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

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing.  
Please refer to [www.lincolnelectric.eu](http://www.lincolnelectric.eu) for any updated information.