



DMV 25.7 N

1. Applications

DMV 25.7 N is a super ferritic-austenitic Cr-Ni-Mo steel with tungsten, copper and nitrogen addition.

The combination of high mechanical properties and excellent corrosion resistance, especially pitting and crevice, presents a good basis for diverse pipe and tube applications such as:

- **Oil & Gas production and processing:**
OCTG (Oil Country Tubular Goods)
Subsea, process and utility services
Umbilical tubing
- **Chemical, Petrochemical, Urea and Food industries** especially in the presence of high stress and high chloride content bearing environments
- **Maritime Applications** ship building; desalination plants; seawater systems

Carbon 0.02	Chromium Cr 25.5	Nickel 7.0	
Molybdenum Mo 3.6	Nitrogen N 0.25	Copper Cu 0.6	Tungsten W 0.7
Manganese Mn 0.5	Silicon Si 0.5	Phosphorus P 0.02	Sulfur <0.002

Chemical composition nominal %

2. Main Features

DMV 25.7 N is characterised by:

- Balanced austenitic - ferritic microstructure
- High mechanical properties: yield strength is more than twice that of austenitic stainless steel grade AISI 316L
- Resistance to general corrosion, pitting, crevice is superior to that of stainless steel grade AISI 316L
- High resistance to stress corrosion cracking and hydrogen sulphide attack
- Typical range of service temperature: -50°C up to +280°C (-58°F up to +540°F)
- Good weldability

3. Description

3.1 Reference Standards

- UNS S32760 acc. to ASTM A 789 / A 790; ASME SA 789 / SA 790; NACE MR0175 / ISO 15156
- 1.4501 acc. to EN 10216-5 or EN 10297-2
- ISO 13680
- API 5LC / DNV OS F101

3.2 Chemical composition

DMV 25.7 N typical values:

	weight %
C	< 0.03
Si	≤ 1.0
Mn	≤ 1.0
P	≤ 0.035
S	≤ 0.015
Cr	25.5
Ni	7.0
Mo	3.6
N	0.2 - 0.3
Cu	0.5 - 1.0
W	0.5 - 1.0
Fe	Balance

PREN ≥ 41
(PREN = %Cr + 3.3 x %Mo + 16 x %N)
PREW ≥ 42
(PREW = %Cr + 3.3 x (%Mo + 0.5 x %W) + 16 x %N)

3.3 Mechanical Properties

Following values are guaranteed in the solution annealed condition:

	MPa	ksi
0.2% Y.S. min.	550	80
U.T.S.	800 - 1000	116 - 145
A% min.	25	

1 MPa=1 N/mm²; 1 ksi=6.9 MPa

3.3.2 Tensile Properties at Elevated Temperature

Temperature	0.2 Y.S. min		
°C	(°F)	MPa	ksi
50	(122)	502	72.8
100	(212)	450	65.2
150	(302)	420	60.9
200	(392)	400	58.0
250	(482)	380	55.1

1 MPa=1 N/mm²; 1 ksi=6.9 MPa

3.3.3 Hardness

DMV 25.7 N has max. 28 HRC / max. 271 HB in conformity with NACE MR0175.

N.B. Higher mechanical values can be achieved in the cold hardened condition.

3.3.4 Impact Resistance

The V-notch impact energy at 20°C (68°F) is min. 100 J (76 ft lb) and at -50°C (-58°F) is min. 60 J (44 ft lb).

N.B. This grade is liable to metallographic modification after prolonged exposure in the range 600 - 900°C (1112 - 1652°F) leading to reduced impact properties. Prolonged service above 280°C (540°F) can also lead to a reduction in impact resistance and increase in hardness.achieved in the cold hardened condition.

3.4 Physical Properties

Density at 20°C (68°F)	
g / cm ³	lbs / in ³
7.95	0.286

Coefficient of Thermal Expansion between 20°C (68°F) and...			
Temperature °C	(°F)	10 ⁻⁶ /K	10 ⁻⁶ /°F
100	(212)	13.6	7.5
200	(392)	14.1	7.8
300	(572)	14.3	8.2
400	(752)	14.7	8.3

Thermal Conductivity		
Temperature °C	W/(m K)	Btu/ (hr ft °F)
20 (68)	13.9	8
100 (212)	15.5	9
200 (392)	16.2	10
300 (572)	18.5	11
400 (752)	20.2	12

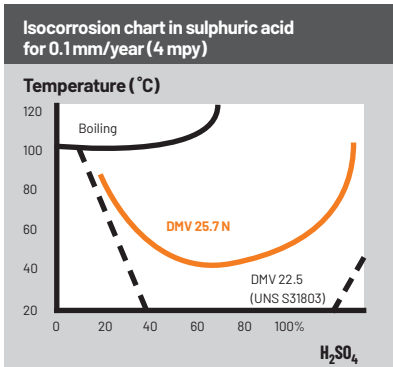
Modulus of Elasticity		
Temperature °C	10 ³ MPa	10 ³ ksi
20 (68)	200	29.0
100 (212)	195	28.3
200 (392)	187	27.1
300 (572)	179	25.9

3.5 Corrosion Properties

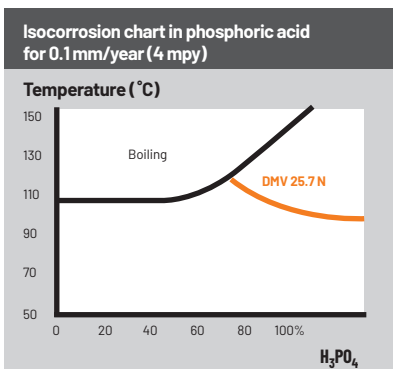
3.5.1 General Corrosion

The chemical composition of DMV 25.7 N has superior resistance to corrosion in

- Sulphuric acid



- Phosphoric acid



- Acetic acid
- Hydrochloric acid
- Organic acids

3.5.2 Intergranular Corrosion

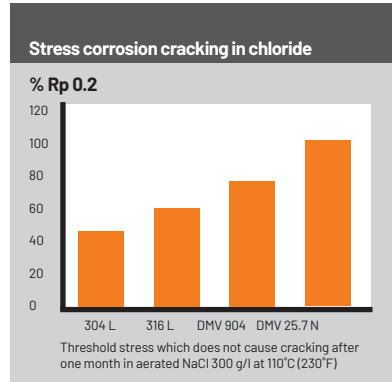
The high chromium level and the austenitic-ferritic structure of DMV 25.7 N ensures to pass the ASTM A 262 E (Strauss test) and ISO 3651-B.

3.5.3 Stress Corrosion Cracking

The austenitic-ferritic structure of this stainless steel confers a high level of resistance to Stress Corrosion Cracking (SCC):

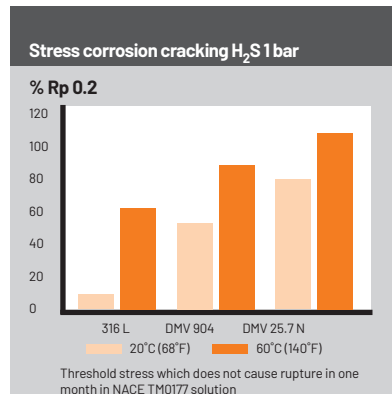
- In chloride environments: (Chloride Stress Cracking - CSC)

The figure below gives the results of stress corrosion cracking in comparison to other stainless steels.



- In H₂S - Cl environments: (Sulphide Stress Cracking - SSC)

For this environment the figure below shows for 1 bar H₂S in comparison to other stainless steels the results:



DMV 25.7 N is approved by NACE MR0175 / ISO 15156-3 for use in sour environment. It shows very good resistance to sulphide stress cracking corrosion test at 24°C (75.2°F) and 90°C (194°F) over 720 hours period (NACE TM0177) in CO₂ - H₂S - Cl media as in table below:

Test solution	NACE TM0177	NACE TM0177
pH ₂ S	1 bar	16 bars
NaCl	50 g/l	50 g/l
Test temp.	24°C (75.2°F)	90°C (194°F)
Stress value	425 N/mm ²	390 N/mm ²
Test results	no failure after 720 h	no failure after 720 h

3.5.4 Pitting and Crevice Corrosion

In 6 weight% FeCl₃ solution (ASTM G 48) the Critical Pitting Temperature (CPT) and Critical Crevice corrosion Temperature (CCT) are, respectively: :

CPT	50°C	122°F
CCT	30°C	86°F

3.5.5 Galvanic Corrosion

Galvanic corrosion can occur when two dissimilar metals are connected. The position of DMV 25.7 N on the electrochemical scale is very similar to that of austenitic stainless steels. This enables it to be coupled with austenitic stainless steels within its passivity range.

4 Supply range

4.1 Dimensional Range

Outside diameter: up to 250 mm (9.84 inches)
Wall thickness: up to 50 mm (1.97 inches).

4.2 Delivery Condition

Pipes and tubes are delivered in cold or hot finished condition depending on size and specification. Normally they will be supplied in annealed condition.

4.3 U-bent

Also available upon request.

5. Fabrication

5.1 Heat Treatment

Pipes and tubes are delivered in the annealed condition.

In case a subsequent processing requires an additional heat treatment, this has to be performed at 1100 - 1140°C (2010 - 2085°F) followed by rapid cooling in air or water.

This is especially recommended when the steel has been exposed in temperature ranges 350 - 525°C (662 - 977°F) and 600 - 950°C.

(1112 - 1742°F) for a long duration causing embrittlement and reduced corrosion resistance.

5.2 Expanding

DMV 25.7 N tubes and pipes can be expanded similarly to austenitic stainless steels, bearing in mind, however, their greater strength. "Close fit" clearance per TEMA is recommended.

5.3 Bending

Cold

Despite their greater strength, during bending DMV 25.7 N tubes behaves similarly to austenitic steels. When plastic deformation exceeds 25%, subsequent heat treatment is necessary.

Hot

Bending is possible in the range 1000 – 950°C (2010 – 1742°F) and must be followed by rapid cooling. It should, however, be noticed that the strength of DMV 25.7 N is low at high temperatures which can have a negative influence on the final shape.

5.4 Cutting and Machining

A higher wear rate of the tools than that of austenitic steels can be noticed when cutting and machining of DMV 25.7 N due to the higher hardness.

5.5 Welding

DMV 25.7 N has a good weldability. Welding is possible with all processes usual for stainless steels. Preheating and heat treatment after welding is normally not necessary.

Butt welding or welding to tube plate is carried out using the gas tungsten arc welding process (TIG / GTAW) with a filler metal having a similar composition (PREN > 41) enriched with elements to favour austenite formation. Use moderate heat input in the range of 10 to 25 kJ / cm.

In all cases it is imperative to remove all traces of superficial oxidation which might initiate localised attack.

6 Standards and References

DMV 25.7 N is delivered in accordance with European, American and other international standards.

Mannesmann Stainless Tubes has delivered DMV 25.7 N tubes and pipes to a wide range of different applications world-wide. You can get more detailed information for the special fields of OCTG, Umbilicals and other oil & gas applications in separate annexes, which are available on request.

For obtaining material samples or specific queries, please contact our sales offices.

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