

SUPER DUPLEX 2507

ASTM A790 UNS S32750 Pipe

Seamless & Welded Pipe | EN 1.4410 | SAF 2507

GNEE STEEL

Professional Super Duplex Stainless Steel Supplier

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01

What is UNS S32750 / Super Duplex 2507?

UNS S32750 (EN 1.4410, SAF 2507, X2CrNiMoN25-7-4, F53) is a **super duplex stainless steel** characterized by a balanced two-phase microstructure of approximately 50% ferrite and 50% austenite. With a Pitting Resistance Equivalent Number (PREN) exceeding 40, it delivers outstanding resistance to pitting and crevice corrosion together with very high mechanical strength — roughly twice that of conventional austenitic grades.

ASTM A790 / A790M covers seamless and welded ferritic-austenitic (duplex) stainless steel pipe for general corrosive service. UNS S32750 is one of the most demanding grades within this specification and is widely specified for seawater, offshore, and aggressive chemical duty.

Key Characteristics

■ Ultra-High Strength

Minimum yield strength of 550 MPa and tensile strength of 800 MPa — allowing thinner walls, lower weight, and reduced installed cost.

■ Outstanding Corrosion Resistance

PREN > 40 gives excellent resistance to pitting, crevice corrosion and chloride stress corrosion cracking (SCC) in seawater and high-chloride media.

■ Good Weldability

Readily welded by GTAW, GMAW, SMAW and SAW using matching ER2594 / E2594 filler metals.

■ Excellent Toughness

Balanced ferrite/austenite ratio provides high resistance to brittle fracture even at low temperature service.

Designation Standards

Standard	Designation
UNS	S32750
EN / DIN	1.4410 (X2CrNiMoN25-7-4)
ASTM / ASME	A790 / A790M, A789, A240, A276, A479, A182
Product Form	Seamless & welded pipe, tube, plate, bar, forgings
Common Trade Name	SAF 2507 / Super Duplex 2507 / F53
NACE / ISO	NACE MR0175 / ISO 15156 (sour service)

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Chemical Composition

The composition of UNS S32750 is carefully balanced to stabilize the duplex microstructure. High chromium, molybdenum and nitrogen contents deliver the corrosion resistance, while nickel and nitrogen control the austenite/ferrite balance.

Element	Symbol	Min (%)	Max (%)	Typical (%)
Carbon	C	—	0.030	0.020
Silicon	Si	—	0.80	0.45
Manganese	Mn	—	1.20	0.85
Phosphorus	P	—	0.035	0.022
Sulfur	S	—	0.020	0.001
Chromium	Cr	24.0	26.0	25.1
Nickel	Ni	6.0	8.0	7.0
Molybdenum	Mo	3.0	5.0	3.8
Nitrogen	N	0.24	0.32	0.28
Copper	Cu	—	0.50	0.20
Iron	Fe	—	Balance	Balance

PREN Requirement

$$\text{PREN} = \% \text{Cr} + 3.3 \times \% \text{Mo} + 16 \times \% \text{N}$$

ASTM A790 requires the calculated PREN of S32750 to be ≥ 40 . Typical value: **41 – 43**, well above Duplex 2205 (35–40) and far above 316L (~24).

PREN is the accepted indicator of resistance to localized pitting corrosion in chloride-bearing environments.

XRF Composition Verification



Portable XRF analyzer confirming UNS S32750 (SS_2507) chemistry on production stock

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Mechanical Properties

Super Duplex 2507 combines very high strength with good ductility and toughness. The values below list the ASTM A790 minimum requirements together with typical values obtained in production testing.

Property	Symbol	A790 Min.	Typical	Unit
Tensile Strength	Rm	800	872	MPa
Yield Strength (0.2% offset)	Rp0.2	550	638	MPa
Elongation (A50)	A	15	32	%
Hardness	HRC	32 max	26	HRC
Ferrite Content	—	35 – 65	48	%
Modulus of Elasticity	E	—	200	GPa
Impact Energy (V-notch, 20°C)	KV	—	100+	J
Poisson's Ratio	v	—	0.30	—

Supplementary Testing

ASTM A790 supplementary requirements include flattening test, flaring test, corrosion test (ASTM A262), hydrostatic or non-destructive electric test, and intermetallic phase detection by **ASTM A923** (Methods A, B and C) which is mandatory for S32750 to confirm freedom from detrimental sigma phase.

Material Test Certificate — Production Data

质量证明书 Mill Inspection Certificate (EN10204 3.1)																		
质量证明书编号 (Certificate No.): 2026101907		合同号 (Contract No.):		特种设备制造许可证编号: T52733007-2027 Manufacture License of Special Equipment														
产品名称 (Commodity): 超级双相不锈钢无缝管 SUPER DUPLEX STAINLESS STEEL PIPE		报告日期 (Date of Report): 2026/10/19		ISO9001证书编号 (ISO9001 Certificate No.): 20226G20340R1M														
产品标准 (Specification): ASTM A790/A790M UNS S32750		购买方 (Purchaser):		交货条件 (Delivery Condition): 固溶退火, 酸洗 Annealed, pickling														
化学成分 Chemical Constituents (%)																		
钢号 Grade	炉号 Heat No.	批号 Lot No.	规格 Size (mm)	支数 Pieces	重量 Weight (kg)	C	Si	Mn	P	S	Ni	Cr	Mo	Cu	N	Ti	Nb	Fe
UNS S32750	FK2610-089	XTD-26083102	168.3×13×6000	897	0.020	0.45	0.85	0.022	0.001	7.02	25.14	3.86	0.20	0.276	/	/	/	Bal.
机械性能 Mechanical Properties																		
测试项目 Test Items	屈服点 Yield Point (MPa)	抗拉强度 Tensile Strength (MPa)	延伸率 A Longation A % (50mm)	硬度 HRC	铁素体含量 Ferrite %	压扁试验 Flattening Test	扩口试验 Flaring Test	晶间腐蚀 Corrosion test	水压试验 HT	涡流探伤 ET	超声探伤 UT							
要求 Requirements	≥550	≥800	≥15%	≤32	ASTM E562	ASTM A1016	ASTM A1016	ASTM A262	ASTM A1016	ASTM E426	ASTM E213							
测试结果 Test Results	638	872	32%	26	48%	合格OK	/	合格OK	合格OK	/	/							
备注 Remark	质量监管部门印章 Q.C. STAMP																	

EN 10204 3.1 Mill Inspection Certificate: Heat FK2610-089, 168.3 × 13 × 6000 mm — Rp0.2 638 MPa / Rm 872 MPa / El 32% / Ferrite 48%

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Physical Properties

Property	Value	Unit	Condition
Density	7.80	g/cm ³	20°C
Melting Range	1350 – 1400	°C	Solidus – Liquidus
Specific Heat Capacity	480	J/kg·K	20°C
Thermal Conductivity	14	W/m·K	20°C
Thermal Expansion	13.5 × 10 ⁻⁶	m/m·K	20 – 100°C
Electrical Resistivity	0.80	μΩ·m	20°C
Magnetic Permeability	Ferromagnetic	—	Duplex structure
Modulus of Elasticity	200	GPa	20°C
Poisson's Ratio	0.30	—	20°C

Notes

- ✓ **Thermal Expansion** — lower than austenitic grades ($\sim 16 \times 10^{-6} / ^\circ\text{C}$), advantageous where thermal cycling or dissimilar-metal joints are involved.
- ✓ **Thermal Conductivity** — approximately 14 W/m·K, higher than austenitic stainless steels, improving heat-exchanger efficiency.
- ✓ **Magnetic Behaviour** — ferromagnetic due to the ferrite phase; residual magnetism should be considered in welding and handling.
- ✓ **Low-Temperature Service** — suitable down to approximately -50°C with adequate impact toughness; below this, ferrite embrittlement must be evaluated.

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Corrosion Resistance

With a PREN above 40, Super Duplex 2507 offers markedly higher resistance to localized corrosion than Duplex 2205 and standard austenitic grades, making it a preferred choice in seawater and high-chloride service.

Corrosion Type	S32750 (2507)	S32205 (2205)	SS 316L	Alloy 904L
Pitting Corrosion	> 1000	> 1000	> 1000	> 1000
Crevice Corrosion	> 1000	> 1000	> 1000	> 1000
Stress Corrosion Cracking	> 1000	> 1000	> 1000	> 1000
General Corrosion	> 1000	> 1000	> 1000	> 1000
Intergranular Corrosion	> 1000	> 1000	> 1000	> 1000
Erosion Corrosion	> 1000	> 1000	> 1000	> 1000

Critical Temperature Data

Parameter	Typical Value	Test Method
Critical Pitting Temperature (CPT)	> 60°C (often 65 – 85°C)	ASTM G48 Method A / E
Critical Crevice Temperature (CCT)	> 40°C	ASTM G48 Method B / F
PREN	41 – 43	Calculation
NORSOK / sour service	Qualified per NACE MR0175	ISO 15156-3

Suitable Service Environments

- ✓ Seawater, brine and chlorinated water systems
- ✓ Offshore and subsea oil & gas production (sour and sweet service)
- ✓ Desalination and reverse-osmosis (RO) plants
- ✓ Chemical and petrochemical processing with high chloride content
- ✓ Flue gas desulfurization (FGD) and scrubber systems
- ✓ Pulp and paper bleaching and digester systems
- ✓ Heat exchangers, condensers and cooling water circuits
- ✓ Fire-fighting and deluge systems requiring seawater resistance

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Applications

Super Duplex 2507 pipe is specified where maximum resistance to chloride attack must be combined with high strength and reduced wall thickness.

Industry	Typical Applications
Oil & Gas / Offshore	Subsea flowlines, risers, umbilical tubing, topside process piping, seawater injection lines
Desalination	RO membrane housings and piping, brine lines, evaporator and heat-exchanger tubing
Chemical / Petrochemical	Reactor and column internals, high-chloride process piping, acid handling lines
Power Generation	FGD absorber piping, condenser tubing, cooling-water and seawater piping
Pulp & Paper	Digester piping, bleach plant lines, liquor and chemical transfer piping
Marine & Shipbuilding	Seawater piping, ballast and firefighting systems, deck and hull fittings
Water Treatment	High-chloride water transfer, filter housings, valve and pump components
Hydraulic & Instrumentation	High-pressure hydraulic tubing, instrument and impulse lines
Mining & Minerals	Slurry and process piping, cyclone and flotation circuits

07

ASTM A790 Pipe Specifications

ASTM A790 / A790M is the standard specification for seamless and welded ferritic-austenitic stainless steel pipe. The tables below summarize the supply capability for UNS S32750.

Item	Specification
Standard	ASTM A790 / A790M, ASME B36.19M (dimensions)
Grade	UNS S32750 (Super Duplex 2507)
Manufacturing	Seamless (hot finished / cold drawn) & welded
Size Range	NPS 1/8 – NPS 24 (seamless); larger sizes on request
Outside Diameter	10.3 mm – 610 mm (up to 914 mm on request)
Wall Thickness	1.24 mm – 40 mm
Schedules	5S, 10S, 40S, 80S and non-schedule / custom wall
Length	Single random 4 – 7 m; Double random 7 – 13 m; fixed lengths on request
Ends	Plain, Beveled, Threaded or with coupling
Heat Treatment	Solution annealed 1025 – 1125°C, water quenched

Standard Schedule Wall Thickness

NPS	OD (mm)	Sch 5S (mm)	Sch 10S (mm)	Sch 40S (mm)	Sch 80S (mm)
1/2	21.3	1.65	2.11	2.77	3.73
3/4	26.7	1.65	2.11	2.87	3.91
1	33.4	1.65	2.77	3.38	4.55
1 1/8	48.3	1.65	2.77	3.68	5.08
2	60.3	1.65	2.77	3.91	5.54
3	88.9	1.65	2.77	5.49	7.62
4	114.3	1.65	3.05	6.02	8.56
6	168.3	1.65	3.40	7.11	10.97
8	219.1	1.65	3.76	8.18	12.70
10	273.1	1.65	4.19	9.27	15.09
12	323.9	1.65	4.57	10.31	17.48
14	355.6	1.65	6.35	11.13	19.05

NPS	OD (mm)	Sch 5S (mm)	Sch 10S (mm)	Sch 40S (mm)	Sch 80S (mm)
16	406.4	1.65	6.35	12.70	21.44
18	457.0	1.65	6.35	14.27	23.83
20	508.0	1.65	6.35	15.09	26.19
24	610.0	1.65	6.35	17.48	30.96

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Dimensional Tolerances

Tolerances are in accordance with ASTM A999 / A999M (general requirements) unless a more restrictive value is agreed at the time of order.

Outside Diameter Tolerance

NPS	Outside Diameter Range (mm)	Tolerance (mm)
1/8 – 1 1/8	10.3 – 48.3	+0.4 / -0.8
Over 1 1/8 – 4	48.3 – 114.3	+0.8 / -0.8
Over 4 – 8	114.3 – 219.1	+1.6 / -0.8
Over 8 – 18	219.1 – 457.2	+2.4 / -0.8
Over 18 – 26	457.2 – 660.4	+3.2 / -0.8
Over 26 – 34	660.4 – 863.6	+3.2 / -1.6
Over 34 – 48	863.6 – 1219.2	+4.0 / -1.6

Wall Thickness Tolerance

Manufacturing Route	Tolerance
Seamless, hot finished	+12.5% / -12.5% of nominal wall
Seamless, cold drawn	+10% / -10% of nominal wall
Welded (with filler / without filler)	+10% / -10% of nominal wall
Minimum-wall ordering	0 / +22.5% (average wall control)

Length, Straightness & Form Tolerances

Parameter	Tolerance
Specific length (up to 6 m)	+10 / -0 mm
Specific length (over 6 m)	+15 / -0 mm
Single random length	4 000 – 7 000 mm
Double random length	7 000 – 13 000 mm
Straightness	max. 0.5 mm per 1 m (0.05%)
Out-of-roundness	max. 1% of specified OD
Wall thickness variation	max. 12.5% of nominal

Weight Tolerance

Order Condition	Tolerance
Single length	+10% / -3.5%
10 lengths or more (lot)	+10% / -1.5%

Tolerances listed above follow ASTM A999/A999M for seamless and welded pipe. Tighter tolerances (e.g. cold-drawn precision tube) can be supplied on request.

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Theoretical Weight Table

Theoretical unit weight is calculated from the nominal outside diameter and wall thickness. Actual weight is subject to the tolerances given in Section 08.

Metric: $W \text{ (kg/m)} = 0.02466 \times t \times (D - t)$, where $D = \text{OD (mm)}$, $t = \text{wall (mm)}$.

Imperial: $W \text{ (lb/ft)} = 10.69 \times t \times (D - t)$, where D, t are in inches.

NPS	OD (mm)	Wall (mm)	Sch	kg/m	lb/ft
1/2	21.3	2.77	40S	1.27	0.85
3/4	26.7	2.87	40S	1.69	1.13
1	33.4	3.38	40S	2.50	1.68
1 1/8	48.3	3.68	40S	4.05	2.72
2	60.3	3.91	40S	5.44	3.66
2	60.3	5.54	80S	7.48	5.03
3	88.9	5.49	40S	11.29	7.59
3	88.9	7.62	80S	15.27	10.27
4	114.3	6.02	40S	16.07	10.81
4	114.3	8.56	80S	22.32	15.01
6	168.3	7.11	40S	28.26	19.00
6	168.3	10.97	80S	42.56	28.62
8	219.1	8.18	40S	42.55	28.61
8	219.1	12.70	80S	64.64	43.46
10	273.1	9.27	40S	60.31	40.56
10	273.1	15.09	80S	96.01	64.56
12	323.9	10.31	40S	79.73	53.62
12	323.9	17.48	80S	132.08	88.83
14	355.6	11.13	40S	94.55	63.59
14	355.6	19.05	80S	158.10	106.34
16	406.4	12.70	40S	123.30	82.94
16	406.4	21.44	80S	203.53	136.90
18	457.0	14.27	40S	155.81	104.80
18	457.0	23.83	80S	254.53	171.21

NPS	OD (mm)	Wall (mm)	Sch	kg/m	lb/ft
20	508.0	15.09	40S	183.42	123.38
20	508.0	26.19	80S	311.22	209.34
24	610.0	17.48	40S	255.40	171.80
24	610.0	30.96	80S	442.08	297.39

Other sizes and wall thicknesses are available on request; weights are calculated values and do not include end machining or coating.

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Surface Treatment

Surface condition is selected according to the service environment. The most common supply condition for ASTM A790 pipe is pickled and passivated, which restores the protective chromium-oxide passive film after heat treatment.

Surface Finish	Description	Typical Application
Pickled and Passivated	Heat treated 1025 – 1125°C (1900 – 2030°F) followed by passivation; removes scale and restores passive film	General corrosive service (standard supply)
Bright Annealed	Heat treated in controlled hydrogen atmosphere; bright, oxide-free surface	Food, instrumentation, clean service
Solution Annealed	Heat treated 1025 – 1125°C then water quenched	Base condition before pickling
Mechanical Polished	Grit 180 / 320 / 400 / 600 finishes	Hygienic, food, pharmaceutical
Mirror Polished	Ra ≤ 0.4 μm	High-purity, decorative
Shot / Sand Blasted	Uniform matte finish, removal of surface contamination	Structural, offshore
Anti-Rust Oil Coated	Temporary protective oil film for transport	Storage and sea freight

All surfaces are free from harmful defects such as cracks, seams, laps and scale. Interior surfaces are cleaned and, where specified, capped to prevent contamination in transit.

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Delivery Condition

Item	Standard Supply Condition
Heat Treatment	Solution annealed at 1025 – 1125°C, followed by rapid water quenching
Microstructure	Balanced ferrite / austenite, typically 35 – 65% ferrite
Surface	Pickled and passivated (acid cleaned) unless otherwise specified
Straightness	Straightened to max. 0.5 mm per 1 m
Ends	Plain or beveled end; protected with plastic caps
Marking	Grade, standard, size, heat number, manufacturer and specification
Certification	EN 10204 3.1 Mill Test Certificate, or 3.2 on request
Delivery State	Annealed + pickling (per certificate shown in Section 03)

Alternative conditions such as cold-drawn, bright-annealed, or as-rolled can be supplied against specific order requirements. Post-weld heat treatment is generally not required, but where specified, solution annealing followed by rapid cooling is recommended.

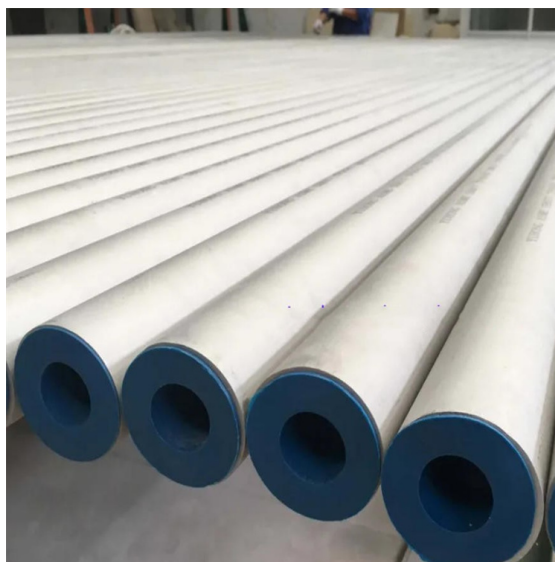
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Pipe End Forms

End Form	Abbrev.	Description	Typical Use
Plain End	PE	Square-cut, deburred ends; no bevel	Small sizes, socket or compression fittings
Beveled End	BE	30° ± 5°; 0°; bevel, root face 1.6 ± 0.8	Butt-welded pipework (standard for large sizes)
Threaded End	TE	NPT / BSP threads, with or without coupling	Screwed connections, low-pressure service
Coupling	—	Threaded coupling attached to one or both ends	Oilfield and water lines
Grooved End	—	Rolled or cut grooves for mechanical couplings	Fast-assembly piping systems
Flanged End	—	Weld-neck or slip-on flange fitted	Connection to equipment and valves

Beveled End Details

Wall Thickness (mm)	Bevel Angle	Root Face (mm)	Root Gap (mm)
≤ 6.0	37.5° ± 2.5°	1.6 ± 0.8	1.6 – 2.4
6.0 – 12.7	30° ± 5°; 0°	1.6 ± 0.8	1.6 – 3.2
> 12.7	30° ± 5°; 0°	2.4 ± 0.8	2.4 – 4.0



Solution-annealed and pickled S32750 pipe with protective plastic end caps

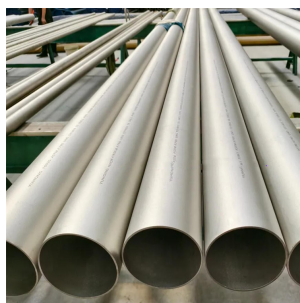
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Products Available from GNEE

GNEE supplies a comprehensive range of Super Duplex 2507 (UNS S32750) products sourced from reputable mills. All products are supplied with full material certification and full traceability from heat number to finished item.



ASTM A790 UNS S32750 seamless pipe with heat-number marking



Large-diameter S32750 seamless pipe ready for despatch



Seaworthy wooden-case packing with moisture barrier

Product Range

Product Type	Standards	Specification Range
Seamless Pipe	ASTM A790 / A789 EN 10216-5	OD 10.3 – 610 mm WT 1.24 – 40 mm Length up to 12 m
Welded Pipe	ASTM A790 / A928 EN 10217-7	OD 21.3 – 1500 mm WT 1.5 – 25 mm
U-Tube / Coil Tube	ASTM A789 / A803	Heat-exchanger U-tubes and coiled tubing, custom sizes
Instrumentation Tube	ASTM A789 / A269	OD 6 – 25 mm, bright annealed, precision tolerance
Fittings	ASTM A815 / A182	Elbows, tees, reducers, caps, couplings
Flanges	ASTM A182 / B16.5 EN 1092-1	WN, SO, BL, threaded, socket weld
Plate / Sheet	ASTM A240 / A480	Thickness 0.5 – 60 mm, width up to 2000 mm
Bar / Rod	ASTM A276 / A479	Diameter 6 – 300 mm

Custom sizes, special wall thicknesses, fixed lengths and third-party inspection can be arranged on request. Please contact our technical team with your specification.

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Certificates & Quality Assurance

Every UNS S32750 pipe is supplied with a full EN 10204 3.1 Mill Test Certificate, and 3.2 certification with third-party witness is available on request. Full traceability is maintained from heat number to finished item.

Certificate / Standard	Description
EN 10204 3.1 / 3.2	Mill Inspection Certificate with chemical and mechanical results
ISO 9001:2015	Quality Management System certification
PED 97/23/EC	Pressure Equipment Directive (EU)
NACE MR0175 / ISO 15156	Sour-service qualification
ASTM A923	Intermetallic phase detection (Methods A, B, C)
TÜV / DNV / SGS	Third-party inspection and certification
PMI (Positive Material Identification)	100% XRF verification available
Hydrostatic / NDT	Hydrostatic, ultrasonic, eddy-current and dye-penetrant testing

Quality Control Sequence

- ✓ Raw-material verification against mill certificate and heat number
- ✓ Chemical composition analysis by optical emission spectrometer
- ✓ Mechanical testing — tensile, yield, elongation, hardness
- ✓ Intermetallic phase check by ASTM A923 and ferrite content measurement
- ✓ Corrosion testing per ASTM A262 / G48
- ✓ Non-destructive examination — UT, ET, PT and hydrostatic test
- ✓ Dimensional and visual inspection of every length
- ✓ Final documentation, marking and release

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Packaging & Delivery

GNEE provides seaworthy packaging designed to protect Super Duplex pipe from mechanical damage, moisture and contamination during transit.

Product	Packing Method
Pipe (small sizes)	Bundled with plastic end caps, wrapped in woven cloth or plastic film, steel strap binding
Pipe (large sizes)	Individual lengths with end caps, wooden saddles or pallets, strapped
U-Tube / Coil	Wooden case with foam and desiccant, individual wrapping
Fittings / Flanges	Wooden case with foam padding, desiccant for sea transport
Bar / Rod	Steel-strap bundle, wooden pallet, anti-rust coating

Packing Features

- ✓ Protective plastic end caps prevent mechanical damage and ingress of moisture
- ✓ Moisture barrier film and desiccant for sea freight
- ✓ Fumigation-free wooden pallets and cases (ISPM 15 compliant)
- ✓ Steel-strap binding with edge protectors
- ✓ Custom marking, labelling and shipping marks per customer requirement
- ✓ Photographs of packing supplied before shipment on request

Marking

Each length is ink-marked with grade (UNS S32750), standard (ASTM A790), size, wall thickness, heat number, manufacturer and specification — as shown on the pipe photograph in Section 13. Example: **A790 UNS S32750 SMLS PIPE 6" × SCH40S HEAT NO.: FK2305-173.**

Delivery & Shipping

- **Lead time:** stock items 3 – 7 days; production orders 15 – 45 days
- **Ports of loading:** Shanghai, Ningbo, Qingdao, Tianjin, Guangzhou
- **Transport:** sea freight (FCL / LCL), air freight, express courier, China–Europe rail
- **Trade terms:** EXW, FOB, CIF, CFR, DAP, DDP
- **Payment terms:** T/T, L/C at sight, Western Union, Trade Assurance

GNEE STEEL**Professional Super Duplex Stainless Steel Supplier**

UNS S32750 · S32205 · S31254 · S32550 · S32760

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