

Austenitic Corrosion Resisting Steel

Material Data Sheet

Steel Designation:

Name

Material No.

X1NiCrMoCu25-20-5

1.4539

Scope

This data sheet applies for hot and cold rolled sheet and strip, semi-finished products, bars, rolled wire and profiles as well as seamless and welded tubes for pressure purposes.

Application

Chemical plants; oil refinery; petrochemical plants; bleaching tanks for the paper industry; combustion gas desulfurization plants; application in sea water, sulphuric and phosphoric acid.

Due to the low C-content, the resistance to **intergranular corrosion** is also guaranteed in the welded condition.

Chemical composition (heat analysis in %)

| Product form | C | Si | Mn | P | S | N | Cr | Cu | Mo | Ni |
|-----------------|--------|--------|--------|--------|--------|--------|---------------|-------------|-----------|---------------|
| C, H, P | ≤ 0.02 | ≤ 0.70 | ≤ 2.00 | ≤ 0.03 | ≤ 0.01 | ≤ 0.15 | 19.00 - 21.00 | 1.20 - 2.00 | 4.00-5.00 | 24.00 - 26.00 |
| L | ≤ 0.02 | ≤ 0.70 | ≤ 2.00 | ≤ 0.03 | ≤ 0.01 | ≤ 0.15 | 19.00 - 21.00 | 1.20 - 2.00 | 4.00-5.00 | 24.00 - 26.00 |
| T _{WS} | ≤ 0.02 | ≤ 0.70 | ≤ 2.00 | ≤ 0.03 | ≤ 0.01 | ≤ 0.15 | 19.00 - 21.00 | 1.20 - 2.00 | 4.00-5.00 | 24.00 - 26.00 |

C = cold rolled strip; H = hot rolled strip; P = hot rolled sheet; L = semi-finished products, bars, rolled wire and profiles;

T_w = welded tubes, T_s = seamless tubes

Mechanical properties at room temperature in solution annealed condition

| Product form | Thick-ness mm _{max} | Yield strength N/mm ² _{min} | | Tensile strength R _m N/mm ² | Elongation | | Impact energy (ISO-V) KV ≥ 10 mm thick | |
|-----------------|---------------------------------|--|--------------------------|---|---|---|--|----------------------------------|
| | | 0,2 % R _{p0,2} | 1 % R _{p1,0} | | A ¹⁾ % _{min} (longitudinal) | A ¹⁾ % _{min} (transverse) | J _{min} (longitudinal) | J _{min} (transverse) |
| C | 8 | 240 ³⁾ | 270 ³⁾ | 530 – 730 ³⁾ | - | 35 | - | - |
| H | 13,5 | 220 ³⁾ | 260 ³⁾ | 530 – 730 ³⁾ | - | 35 | 100 | 60 |
| P | 75 | 220 ³⁾ | 260 ³⁾ | 520 – 720 ³⁾ | - | 35 | 100 | 60 |
| L | 160 | 230 ⁴⁾ | 260 ⁴⁾ | 530 – 730 ⁴⁾ | 35 | - | 100 | - |
| L | 250 ²⁾ | 230 ⁵⁾ | 260 ⁵⁾ | 530 – 730 ⁵⁾ | - | 30 | - | 60 |
| T _{WS} | 60 | 230 ⁶⁾ | 250 ⁶⁾ | 520 – 720 ⁶⁾ | 35 | 30 | 120 | 90 |

1) Gauge length and thickness according to DIN EN

2) > 160 mm

3) Transverse test piece, which product widths < 300 mm long. test piece

4) Longitudinal test piece

5) Transverse test piece

6) Longitudinal test piece, external diameter > 508 mm trans. test piece

Reference data on some physical properties (for guidance only)

| Density at 20 °C kg/dm ³ | Modulus of elasticity kN/mm ² bei | | | | Thermal conductivity at 20 °C W/m K | Special thermal capacity at 20 °C J/kg K | Special electrical resistivity at 20 °C Ω mm ² /m |
|--|---|--------|--------|--------|---|--|--|
| | 20 °C | 200 °C | 400 °C | 500 °C | | | |
| 8,0 | 195 | 182 | 166 | 158 | 12 | 450 | 1,0 |

Mean coefficient of thermal expansion 10⁻⁶ K⁻¹ between 20 °C and

| 100 °C | 200 °C | 300 °C | 400 °C | 500 °C |
|--------|--------|--------|--------|--------|
| 15,8 | 16,1 | 16,5 | 16,9 | 17,3 |

Guidelines on the temperatures for hot forming and heat treatment¹⁾

| Hot forming | | Heat treatment AT (solution annealed), Microstructure | | |
|----------------|-----------------|---|-----------------|----------------|
| Temperature °C | Type of cooling | Temperature °C ²⁾³⁾⁴⁾ | Type of cooling | Microstructure |
| 1150 to 850 | Air | 1010 to 1090 | Water, air | Austenite |

- ¹⁾ For simulative heat treated test pieces the temperatures for solution annealing have to be agreed.
- ²⁾ Solution annealing is in applicable, if the conditions for the hot forming and the concluding cooling are in such a way that the requirements for the mechanical properties of the product can be maintained.
- ³⁾ If heat treatment is carried out in a continuous annealing furnace, usually the upper area of the mentioned temperature range is preferred or even exceeded.
- ⁴⁾ For heat treatment within subsequent processing, the lower area of the stated temperature range for solution annealing has to be aspired, as otherwise the mechanical properties could be affected. If the lower limit for the solution annealing temperature was not undercut during hot forming, while repeating annealing a temperature of 1020 °C as the lower limit is sufficient.

Processing / Welding

Standard welding processes for this steel grade are:

- TIG-welding
- MAG-welding solid wire
- Arc welding (E)
- Submerged arc welding (SAW)
- Laser beam welding

| Processing | Filler metal | | | |
|--------------------|---------------------|--------|------------------------------------|------------------|
| | similar | | higher alloyed | |
| TIG | Thermanit 20/25 Cu | 1.4519 | Thermanit 30/40 E Thermanit 625 | 2.4653 2.4831 |
| MAG solid wire | Thermanit 20/25 Cu | 1.4519 | Thermanit 30/40 E Thermanit 625 | 2.4653 2.4831 |
| Arc welding (E) | Thermanit 20/25 CuW | 1.4519 | Thermanit 30/40 E Thermanit 625 | 2.4653 2.4831 |
| SAW | Thermanit 20/25 Cu | 1.4519 | - | - |
| Laser beam welding | see page 3 | | | |

When choosing the filler metal, the corrosion stress has to be regarded, as well. The use of a higher alloyed filler metal can be necessary due to the cast structure of the weld metal.

A preheating is not necessary for this steel. A heat treatment after welding is normally not usual.

Austenitic steels only have 30 % of the thermal conductivity of non-alloyed steels. Their fusion point is lower than that of non-alloyed steel therefore austenitic steels have to be welded with lower heat input than non-alloyed steels. To avoid overheating or burn-thru of thinner sheets, higher welding speed has to be applied. Copper back-up plates for faster heat rejection are functional, whereas, to avoid cracks in the solder metal, it is not allowed to surface-fuse the copper back-up plate.

This steel has an extensively higher coefficient of thermal expansion as non-alloyed steel. In connection with a worse thermal conductivity, a greater distortion has to be expected.

When welding 1.4539 all procedures, which work against this distortion (e. g. back-step sequence welding, welding alternately on opposite sides with double-V butt weld, assignment of two welders when the components are accordingly large) have to be respected notably. For product thicknesses over 12 mm the double-V butt weld has to be preferred instead of a single-V butt weld. The included angle should be 60° - 70°, when using MIG-welding about 50° are enough. An accumulation of weld seams should be avoided. Tack welds have to be affixed with relatively shorter distances from each other (significantly shorter than these of non-alloyed steels), in order to prevent strong deformation, shrinking or flaking tack welds. The tacks should be subsequently grinded or at least be free from crater cracks.

1.4539 in connection with austenitic weld metal and too high heat input the addiction to form heat cracks exists. The addiction to heat cracks can be confined, if the weld metal features a lower content of ferrite (delta ferrite). Contents of ferrite up to 10 % have a favorable effect and do not affect the corrosion resistance generally. The thinnest layer as possible have to be welded (stringer bead technique) because a higher cooling speed decreases the addiction to hot cracks.

A preferably fast cooling has to be aspired while welding as well, to avoid the vulnerability to intergranular corrosion and embrittlement.

1.4539 is very suitable for **laser beam welding** (weldability A in accordance with DVS bulletin 3203, part 3). With a welding groove width smaller 0,3 mm respectively 0,1 mm product thickness the use of filler metals is not necessary. With larger welding grooves a similar filler metal can be used. With avoiding oxidation within the seam surface during laser beam welding by applicable backhand welding, e. g. helium as inert gas, the welding seam is as corrosion resistant as the

base metal. A hot crack hazard for the welding seam does not exist, when choosing an applicable process.

1.4539 is also suitable for **laser beam fusion cutting** with nitrogen or flame cutting with oxygen. The cut edges only have small heat affected zones and are generally free of micro cracks and thus are well formable. While choosing an applicable process the fusion cut edges can be converted directly. Especially, they can be welded without any further preparation.

While processing only stainless tools like steel brushes, pneumatic picks and so on are allowed, in order to not endanger the passivation.

It should be neglected to mark within the welding seam zone with oleigerous bolts or temperature indicating crayons.

The high corrosions resistance of this stainless steel is based on the formation of a homogeneous, compact passive layer on the surface. Annealing colors, scales, slag residues, tramp iron, spatters and such like have to be removed, in order to not destroy the passive layer.

For cleaning the surface the processes brushing, grinding, pickling or blasting (iron-free silica sand or glass spheres) can be applied. For brushing only stainless steel brushes can be used. Pickling of the previously brushed seam area is carried out by dipping and spraying, however, often pickling pastes or solutions are used. After pickling a carefully flushing with water has to be done.

Remark

In quenched condition the material can be slightly magnetizable. With increasing cold forming the magnetizability increases.

Editor

THYSSENKRUPP MATERIALS INTERNATIONAL GMBH
 Technical Sales / Quality management)
 Am Thyssenhaus 1
 45128 Essen

References

DIN EN 10088-2:2005-09
 DIN EN 10088-3:2005-09
 DIN EN 10216-5:2004-11
 DIN EN 10217-7:2005-05

MB 821 "Properties"

MB 822 "The converting of stainless steel"

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Laser beam electric arc cutting of stainless steels Thyssen Lasertechnik GmbH, Aachen

Laser beam – longitudinal welding of profiles of stainless steel

Böhler Schweisstechnik Deutschland GmbH, Hamm

Important note

Information given in this data sheet about property or applicability of materials respective products is no assurance of characteristics but serve for description.

Information, with which we like to advise you, relate to the experience of the producers and our own. Warranty for the results of the treatment and application of the products cannot be granted.