

ASTM A928 UNS S32750 EFW Pipe Specification

Product Description:

- **Standard:** ASTM A928 / ASME SA928
- **Material Grade:** UNS S32750 (equivalent to DIN 1.4410, Super Duplex 2507)
- **Product Form:** Electric Fusion Welded (EFW) Pipe
- **Manufacturing Process:** Welded from plate using an electric fusion welding process with or without filler metal
- **Dimensions & Tolerances**

Size Range	½" NB to 48" NB (DN15 - DN1200)
Wall Thickness	SCH 10S to SCH XXS or as per customer requirements
Length	5.8 m / 6 m / 11.8 m / 12 m or custom cut-length
Tolerances	As per ASTM A999 (General Requirements)
End Finish	Beveled, plain, or threaded ends

Chemical Composition of UNS S32750

UNS Desig.	Type	C	Mn	P	S	Si	Cr	Ni	Mo	N	Cu	Other Elements
S32750	2507	0.03	1.2	0.035	0.02	0.8	24.0 - 26.0	6.0 - 8.0	3.0 - 5.0	0.24 - 0.32	0.5	...

Mechanical Property of UNS S32750

UNS Designation	Type	Tensile Strength, min (ksi)	Tensile Strength, min (MPa)	Yield Strength, min (ksi)	Yield Strength, min (MPa)	Elongation in 2 in. or 50 mm, min, %	Hardness, max - Brinell, HBW	Hardness, max - Rockwell	Cold Bend
S32750	2507	116	795	80	550	15	310	32 HRC	not required

Heat treatment of UNS S32750

UNS Designation	Grade	Temperature, °F [°C]	Quench
S32750	2507	1880–2060 [1025–1125]	rapid cooling in air or water

UNS S32750 Pipe and Metal Filler Specification

UNS Designation	Grade	ASTM Plate Specification No. and Grade	A5.4 Class	A5.4 UNS	A5.9 Class	A5.9 UNS	A5.11 Class	A5.11 UNS	A5.14 Class	A5.14 UNS	A5.22 Class	A5.22 UNS
S32750	2507	A240 S32750	E2594...	W39594...	ER2594...	S32750...	B	B	B	B	B	B

Testing & Inspection Requirements

Test	Requirement
Hydrostatic Test	Mandatory unless waived by purchaser
Nondestructive Testing	100% Radiographic (RT), Ultrasonic (UT), or Eddy Current
Weld Seam Examination	As per ASTM A928, Section 10
Visual & Dimensional	As per ASTM A999 and A928
PMI (Positive Material ID)	On request
Intergranular Corrosion	Optional (ASTM A262 Practice E)

