

DATA SHEET

DMV 22.5

1 – Applications

DMV 22.5 is a duplex (austenitic – ferritic) Cr-Ni-Mo-steel with nitrogen addition.

The combination of high mechanical properties and good 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) more details in Annex 1
Subsea, process and utility services more details in Annex 2
- **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

2 – Main Features

DMV 22.5 is characterised by:

- Balanced austenitic - ferritic microstructure
- High mechanical properties: yield strength is about 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 S31803 / S32205 acc. to ASTM A 789 / A 790; ASME SA 789 / SA 790; NACE MR0175 / ISO 15156
- 1.4462 acc. to EN 10216-5; EN 10297-2; VdTÜV data sheet 418
- ISO 13680 – see Annex 1
- API 5LC / DNV OS F101 – see Annex 2

3.2 Chemical Composition

DMV 22.5 typical values

	weight-%
C	0.02
Si	0.4
Mn	1.7
P	0.02
S	< 0.002
Cr	22.0
Ni	5.3
Mo	3.2
N	0.17
Fe	Balance

$$PRE_N \geq 35$$

$$(PRE_N = \%Cr + 3.3 \times \%Mo + 16 \times \%N)$$

3.3 Mechanical Properties

Following values are guaranteed in the solution annealed condition:

3.3.1 Tensile Properties at 20°C (68°F)

	MPa	ksi
0.2% Y.S. min.	485	70
U.T.S.	640 - 920	93 - 133
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)	415	60
100	(212)	360	52
150	(302)	335	48
200	(392)	310	45
250	(482)	295	42

1 MPa=1 N/mm²; 1 ksi=6.9 MPa

3.3.3 Hardness

DMV 22.5 has max. 26 HRC / max. 260 HB conformity with NACE MR0175.

N.B. Higher mechanical values can be achieved in the cold hardened condition – see Annex 1.

3.3.4 Impact Resistance

The V-notch impact energy at 20°C (68°F) is min. 90 J (67 ft lb) and at -46°C (-51°F) is min. 45 J (34 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.

3.4 Physical Properties

Density at 20°C (68°F)	
g / cm ³	lbs / in ³
7.8	0.28

Coefficient of Thermal Expansion between 20°C (68°F) and...			
Temperature		10 ⁻⁶ / K	10 ⁻⁶ / °F
°C	(°F)		
100	(212)	13.1	7.1
200	(392)	13.6	7.6
300	(572)	14.1	8.1
400	(752)	14.6	8.2

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Thermal Conductivity

Temperature °C (°F)	W / (m K)	Btu / (ft h °F)
20 (68)	13.9	8
100 (212)	15.8	9
200 (392)	16.8	10
300 (572)	19.2	11
400 (752)	20.2	12

Modulus of Elasticity

Temperature °C (°F)	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

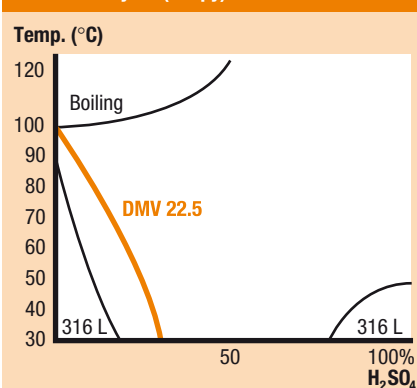
3.5 Corrosion Properties

3.5.1 General Corrosion

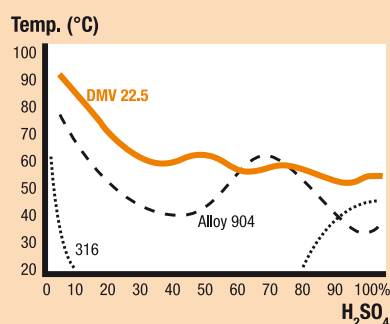
The chemical composition of DMV 22.5 makes it more resistant to corrosion than AISI 316L stainless steel in many corrosive environments like:

- Sulphuric acid

Isocorrosion chart in sulphuric acid for 0.1 mm/year (4 mpy)

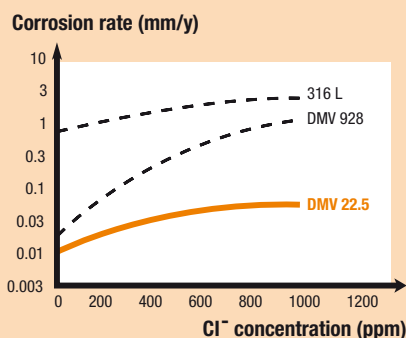


Sulphuric acid + 0.5% NaCl



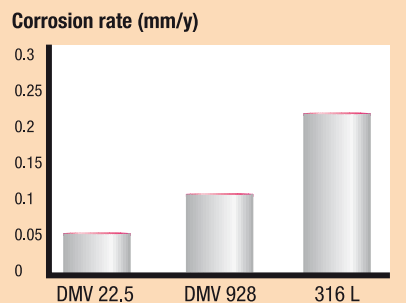
- Acetic acid

Acetic acid 80% T = 140°C (284°F)



- Mixture of acetic and formic acids

Acetic acid 50% + formic acid 20% Boiling point



- Hydrochloric acid

- Organic acids

3.5.2 Intergranular Corrosion

In the annealed condition, without any sensitization treatment, corrosion rates in boiling nitric acid to ASTM A 262-C, remain below 1.1 mm/y (6.1 µm / 48h) which is equal to 3.7 mils / month. After sensitization, DMV 22.5 meets the require-

ments of copper – copper sulfate - sulfuric acid intercrystalline tests such as ASTM A 262-E (Strauss test) or 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 most industrial diluted chloride media when stress level is below the yield strength.

- In chloride environments:

(Chloride Stress Cracking - CSC)

The table below gives the results of stress corrosion cracking tests after 500 hours in three different boiling chloride solutions and with three kinds of test pieces: U bent, 4 point bent-beam and C ring:

	Test piece	DMV 22.5	316L
MgCl ₂ 45% boiling 155°C (310°F)	U bent (1)	F	F
	4 points (2)	100%	50%
	C ring (3)	25%	5%
CaCl ₂ 50% boiling 150°C (302°F)	U bent (1)	F	F
	4 points (2)	100%	50%
	C ring (3)	100%	50%
NaCl ₂ 25% boiling 110°C (230°F)	U bent (1)	NF	F
	4 points (2)	100%	50%
	C ring (3)	100%	50%

1. F = failure NF = no failure

2. 4 points bent-beam test - stress before rupture (percentage of Y.S.)

3. C ring test - stress before rupture (percentage of Y.S.)

- In H₂S - Cl environments:

(Sulphide Stress Cracking - SSC)

DMV 22.5 is an austenitic-ferritic stainless steel approved by NACE MR0175 / ISO 15156-3 for use in sour environment. DMV 22.5 shows 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 indicated in the table below:

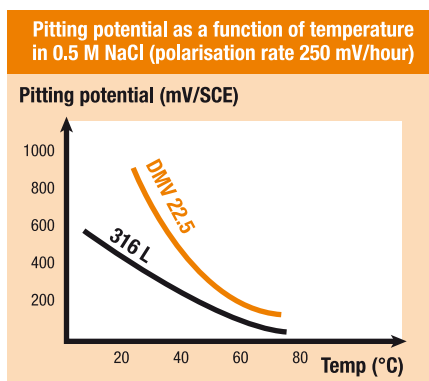
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Test solution	NACE TM0177	NACE TM0177
pH ₂ S	1 bar	16 bars
NaCl	50 g/l	50 g/l
Test temperature	24°C (75.2°F)	90°C (194°F)
Stress value	350 N/mm ²	325 N/mm ²
Test results	no failure after 720 h	no failure after 720 h

3.5.4 Pitting and Crevice Corrosion

The resistance to pitting and crevice corrosion increases with the content of chromium, molybdenum and nitrogen in the steel. Due to the relatively high level of these three elements, DMV 22.5 has noticeably better resistance to this type of corrosion than AISI 316L, as shown on the graph below.



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

CPT	30°C	86°F
CCT	20°C	68°F

3.5.5 Galvanic Corrosion

Galvanic corrosion can occur when two dissimilar metals are connected. The position of DMV 22.5 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

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 1020 - 1100°C (1870 - 2010°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) or 600 - 950°C (1112 - 1742°F) for a long duration causing embrittlement and reduced corrosion resistance.

5.2 Expanding

DMV 22.5 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 22.5 tubes behaves similarly to austenitic steels. When plastic deformation exceeds 25%, subsequent heat treatment is necessary. In case of special applications where VdTÜV datasheet 418 is specified, heat treatment is mandatory if deformation exceeds 10%.

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 22.5 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 22.5 due to the higher hardness.

5.5 Welding

DMV 22.5 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 (PRE_N > 35) 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 22.5 is delivered in accordance with European, American and other international standards.

Salzgitter Mannesmann Stainless Tubes has delivered DMV 22.5 tubes and pipes to a wide range of different applications world-wide.

You can get more detailed information for the special fields of OCTG 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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