

## CLASSIFICATIONS

EN ISO 14343-A : G 25 20

EN ISO 14343-A : W 25 20

AWS A5.9 : ER 310

## DESCRIPTION

- Applicability in cement and ceramic industries, in manufacturing processes of industrial furnaces, oil refineries, in welding of steel and steel castings used in steam boiler manufacturing
- Suitability of weld metal for use at temperatures between -196°C and 1200°C
- Suitability for both TIG and MIG welding
- Requirement of use of Ar as shielding gas in TIG welding, and of Ar+ %2.5 O<sub>2</sub> or Ar+ %2.5 CO<sub>2</sub> mixed gas as shielding in MIG welding

## CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL)

C: 0.12 | Si:0.5 | Mn: 1.6 | Cr: 25.0 | Ni: 20.5

## MECHANICAL PROPERTIES

Yield Strength (MPa)	Tensile Strength (MPa)	Impact Strength (ISO-V/+20°C)	Elongation (L <sub>0</sub> =5d <sub>0</sub> ) (%)
min. 350	550 - 720	min. 63 J	min. 30

## BASE MATERIALS

- X15CrNiSi 25 20, X12CrNi 25 21, X15CrNi 20 12, G-X15CrNi 25 20, G-X40 CrNi 25 21, X10CrAl 7, X10CrAl 18, X10CrAl 24, 305, 310, 314, A297 HF, A297 HJ

## WELDING POSITIONS



## CURRENT CONDITION

TIG D.C.(-) / MIG D.C.(+)

## OPERATING DATA

Product Code	Diameter x Length (mm) / (inch)		Weight (Kg)	Package Type
1011100036	0,8	0.030"	12.5	BS 300
1011100037	1	0.040"	15	BS 300
1011100038	1,2	0.047"	15	BS 300
1011100039	1,60 x 1000	1/16 x 39"	5	Plastic Box
1011100040	2,00 x 1000	5/64 x 39"	5	Plastic Box
1011100041	2,40 x 1000	3/32 x 39"	5	Plastic Box
1011100042	3,20 x 1000	1/8 x 39"	5	Plastic Box