

Classification

AWS A 5.4 : E 310- 16

DIN 8556: E 25 20 R 23

DIN EN 1600: E 25 20 R 12

Werkstoff Nr: 1.4842

Description and applications

Rutile-basic electrode with a high temperature austenitic stainless steel deposit. Resistant to corrosion and oxidation up to 1200°C, good resistance against hot cracks, easy slag removal and nice aspect of the beads.

Principal applications: construction of steam boilers, chemical installations, gas industry, ovens, thermal equipments.

Base materials

Stainless steels and high temperature steels:

UNS	Alloy	EN	Material N°	UGINE
S31000	310	X15CrNiSi25-20	1.4841	
S31008	310S	X12CrNi25-21	1.4845	UGINOX R 25-20
S31400	314	X15CrNiSi	1.4841	
S30900	309	X15CrNiSi20-12	1.4828	UGINOX R 20-12
		G-X15CrNi25-20	1.4840	
J93503		G-X40CrNiSi25-12	1.4837	
J94204	HK40	G-X40CrNiSi25-20	1.4848	

All weld metal mechanical properties (typical)

Tensile strength Rm (N/mm²)

≥ 550

Elongation (%)

≥ 30

ISO- V (J) RT

≥ 60

Typical weld metal chemical composition (%)

C	Si	Mn	Cr	Ni	S	P
0.10	0.70	2.00	27.00	21.00	0.012	0.020

Amperes (A)

2.50

60-90

3.15

80-110

4.00

100-140

5.00

150-180

Storage and redrying

Keep dry and avoid condensation. Redry generally not required. If necessary redry at 300- 350°C for 2 hrs., 4 times max.

Welding instruction

Avoid prolonged stay at 600-850°C (sigma phase formation).



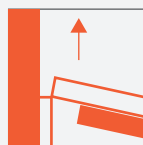
1G/PA



2F/PB



2G/PC



3G/PF



4G/PE

