

Description

Bare, corrosion-resistant, chromium-nickel welding rod for welding heat-resistant austenitic steels of the 25Cr-20Ni type.

The wire has a high Cr content and provides good oxidation resistance at high temperatures. Common applications include industrial furnaces and boiler parts, as well as heat exchangers.

Welding current

DC(-)

Classifications

SFA/AWS A5.9	ER310
EN 12072	W 25 20

Wire composition

C	Si	Mn	Cr	Ni	Mo	Cu
0.1	0.5	1.8	26.0	21.0	<0.3	<0.3

Typical mech. properties all weld metal

Yield stress, MPa	390
Tensile strength, MPa	590
Elongation, %	43

Charpy V

Test temps, °C	Impact values, J
+20	175
-196	60

Packing data

Diameter, mm	Length, mm	Weight of rods/ box, kg
1.6	1000	5.0
2.0	1000	5.0
2.4	1000	5.0
3.2	1000	5.0