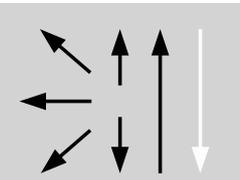


Classifications					
EN ISO 3581-A	AWS A5.4			Mat. No.	
E 25 20 B 2 2	E310-15 (mod.)			1.4842	
Characteristics and typical fields of application					
Resistant to scaling up to 1150 °C (2102 °F). For surfacing and joining applications on matching/similar heat resistant steels / cast steel grades. For tough fill layers beneath cap passes made with Thermanit L when welding thicker cross sections of Cr steels/cast steel grades to permit use of such steels in sulphureous atmospheres.					
Atmosphere		max. application temperature in °C (°F)			
Air and oxidizing combustion gases		sulphur-free	max. 2 g S/Nm ³		
Reducing combustion gases		1150 (2102)	1100 (2012)		
		1080 (1976)	1040 (1904)		
Base materials					
TÜV certified parent metal 1.4841 – X15CrNiSi25-20; AISI 305, 310, 314; ASTM A297HF, A297HJ					
Typical analysis of all-weld metal (wt.-%)					
	C	Si	Mn	Cr	Ni
wt-%	0.13	1.0	2.5	25.0	20.0
Structure: Austenite					
Mechanical properties of all-weld metal					
Heat-treatment	Yield strength R _{p0.2}	Yield strength R _{p1.0}	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Impact work ISO-V KV J
	MPa	MPa	MPa	%	+20 °C
aw	350	390	550	25	80
Operating data					
	Polarity: DC (+)	ø (mm)	L mm	Amps A	
		2.5	300	55 – 75	
		3.2	350	70 – 110	
		4.0	350	90 – 140	
		5.0	450	140 – 190	
Welding instruction					
Materials		Preheating	Postweld heat treatment		
Heat resistant Cr steels / cast steel grades		According to parent metal	According to parent metal		
Heat resistant matching / similar steels / cast steel grades		None	None		
Approvals					
TÜV (01232), CE					