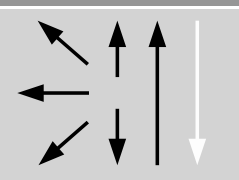


Classifications					
EN ISO 3581-A	AWS A5.4		Mat. No.		
E 22 12 R 3 2	E309-17		1.4829		
Characteristics and typical fields of application					
Resistant to scaling up to 950 °C (1742 °F). For joining and surfacing applications on matching/similar heat resistant steels / cast steel grades.					
Atmosphere		max. application temperature in °C (°F)			
		sulphur-free	max. 2 g S/Nm ³	over 2 g S/Nm ³	
Air and oxidizing combustion gases		950 (1742)	930 (1706)	850 (1562)	
Reducing combustion gases		900 (1652)	850 (1562)		
Base materials					
TÜV certified parent metal / 1.4828 – X15CrNiSi20-12; AISI 305; ASTM A297HF					
Typical analysis of all-weld metal (wt.-%)					
	C	Si	Mn	Cr	Ni
wt-%	0.11	< 0.9	0.8	22.5	12.5
Structure: Austenite with part ferrite					
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	320	340	550	30	55
Creep rupture properties: In the range of matching heat resistant parent metals					
Operating data					
	Polarity: DC (+) / AC	ø (mm) 2.5 3.2	L mm 350 350	Amps A 50 – 80 80 – 110	
Welding instruction					
Materials	Preheating	Postweld heat treatment			
Heat resistant Cr-steels / cast steel grades	According to parent metal	Annealing according to parent metal is not necessary if service temperature the same or higher			
Matching austenitic steels / cast steel grades	None	None			
Approvals					
TÜV (01315), CE					