


25/20 R AC/DC+
STAINLESS STEEL
DESCRIPTION

Rutile-basic electrode with a high temperature resistant austenitic stainless steel deposit. Resistant to corrosion and oxidation up to 1200°C (2192°F), good resistance against hot cracks, easy slag removal and nice aspect of the weld beads.

CLASSIFICATION

AWS A5.4: ~ E310-16 EN 1600: E 25 20 R 32 ISO 3581-A: E 25 20 R 32

TYPICAL APPLICATIONS

Construction of steam boilers, chemical installations, gas industry, ovens, thermal equipment.

BASE MATERIALS 310, 310S, 314, 309, HK40

PROCEDURE

Redrying 2h at 250°C if necessary. Avoid prolonged stay at 600-850°C (sigma phase formation).
Interpass temperature: < 150°C (300°F)

MECHANICAL PROPERTIES

Tensile strength: > 79 770 psi (550 MPa)
Yield strength: > 58 015 psi (400 MPa)
Elongation: > 30 %
Impact (Charpy V): > 60 J at +20°C

TYPICAL WELD METAL COMPOSITION (%)

C	Mn	Si	Ni	Cr
0.1	2.0	0.90	20.5	25.5

WELDING PARAMETERS

Diameter: 4.0 mm (5/32") 3.2 mm (1/8") 2.5 mm (3/32")
Amperage: 125-145 A 90-110 A 60-80 A

WELDING POSITIONS


1G/PA



2F/PB



2G/PC



3G/PF



4G/PE

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