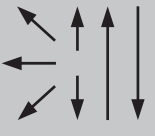


Solid wire, high-alloyed

Classifications					
EN ISO 14343-A		AWS A5.9		Mat. No.	
G 25 20 Mn		ER310(mod.)		1.4842	
Characteristics and typical fields of application					
Resistant to scaling up to 1150 °C (2102 °F). For surfacing and joining 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)			
		sulphur-free		max. 2 g S/Nm ³	
Air and oxidizing combustion gases		1150 (2102)		1100 (2012)	
Reducing combustion gases		1080 (1976)		1040 (1904)	
Base materials					
1.4837 –GX40CrNiSi25-12; AISI 305, 310, 314; ASTM A297 HF, A297HJ		1.4840 – GX15CrNi25-20;		1.4841 – X15CrNiSi25-20	
Typical analysis of solid wire (wt.-%)					
C	Mn	Si	Cr	Ni	
0.13	3.2	1.0	25.0	20.5	
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	380	550	25	80
Creep rupture properties: In the range of matching heat resistant parent metals					
Operating data					
	Ø (mm)	Polarity:	Shielding gas:	Spool:	
	0.8	DC (+)	(EN ISO 14175)	BS300	
	1.0		M13, M12	B300	
	1.2			B300	
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					
