

## Standards

TS EN ISO 3581-A	: E 25 20 B 22
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AWS A5.4	: ~E 310-15

## Chemical Composition of Weld Metal % (Typical)

C	Si	Mn	Ni	Cr
0.12	0.9	3.0	20.5	25.0

## Mechanical Properties

Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Impact Strength (ISO-V/+20°C)	Elongation (L <sub>0</sub> =5d <sub>0</sub> ) (%)
min. 355	560-690	100 J	min. 25

## Typical Base Material Grades

- X15CrNiSi 25 20, X12CrNi 25 21, X15CrNiSi 20 12, G-X 15CrNi 25 20, G-X 40CrNi 25 21, G-X40CrNiSi22 9, X10CrAl 18, X10CrAl 24, G-X40CrSi 17, AISI 305, 310, 314.

## Features and Applications

- Austenitic CrNi steels, ferritic CrNiAl alloyed steels, heat-resisting rolled, forged and cast steels used in ceramic, petrochemical industries and furnace, boilers, chimney applications
- Weld metal is resistant to working temperature - 196°C up to +1200°C

## Welding Positions



## Current Type

D.C.(+)

## Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010101188	2.50 x 250	3/32 x 10"	50 - 80	1440
3010101193	3.20 x 300	1/8 x 1 2"	80 - 110	2710
3010101198	3.20 x 350	1/8 x 1 4"	80 - 110	3120
3010101203	4.00 x 350	5/32 x 1 4"	110 - 140	4750

**Approvals:** TSE, CE, SEPRO