

Standards

TS EN ISO 3581-A : E 25 4 B 22
EN ISO 3581-A : E 25 4 B 22

**Chemical Composition of
Weld Metal % (Typical)**

C	Si	Mn	Ni	Cr
0.12	0.4	1.3	5.0	25.5

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/+20°C)	Elongation (L ₀ =5d ₀) (%)
min. 500	650-780	min. 30 J	min. 15

Typical Base Material Grades

- EN: X20CrNiSi 25 4, G-X40CrNiSi 27 4, X10CrAl7, X10CrAl 13, X10CrAl 18, X10CrAl 24, G-X30CrSi 6, G-X40CrSi 17
- AISI: 327

Features and Applications

- Used for the fabrication of furnace, boilers, etc. That made of heat resistant steels (CrNi and CrNiAl alloyed steels)
- For furnace requiring elevated resistance to reducing and oxidizing sulphurous gases as well as for final passes of weld joints in heat-resistant CrSiAl-steels
- Scaling resistance up to 1100°C

Welding Positions

Current Type

D.C.(+)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010101373	2.50 x 250	3/32 x 10"	50 - 80	1560
3010101378	3.20 x 350	1/8 x 14"	80 - 105	3270
3010101383	4.00 x 350	5/32 x 14"	100 - 130	4940

Approvals: TSE, CE, SEPRO