

Standards

TS EN ISO 3581-A	: E Z 20 25 5 Cu N L B 22
EN ISO 3581-A	: E Z 20 25 5 Cu N L B 22
AWS A5.4	: E 385 -15

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

C	Si	Mn	Mo	Ni	Cr	Cu	Nb
<0.025	0.40	2.2	3.5	25.0	22.0	2.2	0.35

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/+20°C)	Elongation (L ₀ =5d ₀) (%)
min. 380	600-700	80 J	min. 35

Typical Base Material Grades

- EN & DIN: X5NiCrMoCuNb 20 18, X5NiCrMoCuTi 20 18, X2NiCrMoCu 25 20 5, X5NiCrMoCuNb 22 18, G-X7CrNiMoCuNb 18 18, G-X7NiCrMoCuNb 25 20
- AISI: 307, 307L, 904L

Features and Applications

- Basic coated alloyed-core wire special electrode for corrosion - resistant high-Molybdenum CrNi steels
- Recommended for highly corrosive environments
- Apart from its markedly good chemical resistance to stress corrosion cracking and crevice corrosion, the weld metal features high resistance to pitting
- Particularly recommended for steels containing up to 5% molybdenum

Welding Positions

Current Type

D.C.(+)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010101443	2.50 x 250	3/32 x 10"	50 - 90	1573
3010101448	3.20 x 350	1/8 x 14"	80 - 120	3563
3010101453	4.00 x 350	5/32 x 14"	110 - 150	4570

Approvals: TSE, CE, SEPRO