

**Standards**

TS EN ISO 3581-A	: E 25 20 R 32
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AWS A5.4	: ~E 310-16

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

C	Si	Mn	Ni	Cr
0.12	0.9	2.5	20	26.0

**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	min.47 J	min. 25

**Typical Base Material Grades**

- Furnace, boilers, pipes made of Cr-Ni and Cr-Si-Al alloyed steels.
- X15CrNiSi 25-20, X15CrNiSi 25-21, X15CrNiSi 20-12, G-X40CrNi25, GX40CrNiSi229, X10CrAl, X10CrAl24, GX40CrSi1, AISI 305, 310, 304

**Features and Applications**

- Weld metal is resistant to working temperatures up to +1200°C
- Used with alternative current also
- Requirement of Re-drying for min. 2 hours at the temperatures between 120°C and 200°C

**Welding Positions**

**Current Type**

D.C.(+)/ A.C.

**Operating Data**

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010101158	2.50 x 250	3/32 x 10"	50 - 80	1410
3010101163	3.20 x 300	1/8 x 1 2"	80 - 110	2930
3010101168	3.20 x 350	1/8 x 1 4"	80 - 110	3460
3010101173	4.00 x 350	5/32 x 1 4"	110 - 140	5300

**Approvals:** TSE, CE, SEPRO