

Standards

TS EN ISO 3581-A : E 20 25 5 Cu N L R 32
EN ISO 3581-A : E 20 25 5 Cu N L R 32
AWS A5.4 : E 385 -16

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

C	Si	Mn	Mo	Ni	Cr	Cu
<0.03	0.75	1.0	4.5	25.0	20.0	1.5

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/+20°C)	Elongation (L ₀ =5d ₀) (%)
min. 400	550-700	min. 47 J	min. 30

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: 317L, 904L

Features and Applications

- Resistant to intercrystalline corrosion / wet corrosion up to 350°C
- High corrosion resistance similar to that of matching steels / cast steel grades, above all in reducing environments
- For joining and surfacing work on matching austenitic CrNiMoCu steels/cast steel grades
- For joining these types of steels with unalloyed / low alloy steels / cast steel grades
- Re-drying: 120°C - 200°C / min. 2h

Welding Positions

Current Type

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

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010101428	2.50 x 250	3/32 x 10"	50 - 90	1570
3010101433	3.20 x 350	1/8 x 14"	80 - 120	3470
3010101438	4.00 x 350	5/32 x 14"	110 - 160	5200

Approvals: TSE, CE, SEPRO