

Standards

TS EN ISO 14343-A	: G 25 20
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TS EN ISO 14343-A	: W 25 20
EN ISO 14343-A	: W 25 20
AWS A5.9	: ER 310

**Chemical Composition of
Welding Wire % (Typical)**

C	Si	Mn	Cr	Ni
0.12	0.5	1.6	25.0	20.5

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/+20°C)	Elongation (L ₀ =5d ₀) (%)
min. 350	550 - 720	min. 63 J	min. 30

Typical Base Material Grades

- X15CrNiSi 25 20, X12CrNi 25 21, X15CrNi 20 12, G-X15CrNi 25 20, G-X40 CrNi 25 21, X10CrAl 7, X10CrAl 18, X10CrAl 24, 305, 310, 314, A297 HF, A297 HJ

Features and Applications

- Applicability in cement and ceramic industries, in manufacturing processes of industrial furnaces, oil refineries, in welding of steel and steel castings used in steam boiler manufacturing
- Suitability of weld metal for use at temperatures between -196°C and 1200°C
- Suitability for both TIG and MIG welding
- Requirement of use of Ar as shielding gas in TIG welding, and of Ar+ %2.5 O₂ or Ar+ %2.5 CO₂ mixed gas as shielding in MIG welding

Welding Positions

Current Type

TIG D.C.(-) / MIG D.C.(+)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Weight (Kg)	Package Type
6011100402	0,8	0.030"	12.5	BS 300
6011100338	1	0.040"	15	BS 300
6011100374	1,2	0.047"	15	BS 300
6011100339	1,60 x 1000	1/16 x 39"	5	Plastic Box
6011100340	2,00 x 1000	5/64 x 39"	5	Plastic Box
6011100341	2,40 x 1000	3/32 x 39"	5	Plastic Box
6011100342	3,20 x 1000	1/8 x 39"	5	Plastic Box

Approvals: CE, SEPRO