

## Classifications

**EN ISO 3581-A**

E Z 25 35 Nb B 2 2

## Characteristics and typical fields of application

Thermanit 25/35 R is suitable for joining and surfacing of heat resistant CrNi-cast steels (centrifugal and mould cast parts) of the same or of similar nature. Resistant to scaling up to 1050°C

## Base materials

1.4840 GX15CrNi25-20, 1.4849 GX40NiCrSiNb38-18, 1.4852 GX40NiCrSiNb35-25, 1.4857 GX40NiCrSi35-25, 1.4865 GX40NiCrSi38-18

## Typical analysis


	C	Si	Mn	Cr	Ni	Nb	Ti
wt.-%	0.40	1.0	1.8	25.0	35.0	1.3	0.1

## Mechanical properties of all-weld metal - typical values (min. values)

Condition	Yield strength $R_{p0.2}$	Tensile strength $R_m$	Elongation A ( $L_0=5d_0$ )
	MPa	MPa	%
u	(≥ 500)	(≥700)	(≥ 15)

u untreated, as-welded

## Operating data

	Polarity	DC+	Dimension mm	Current A
	Electrode identification	Thermanit 25/35 R	2.5 × 300	50 – 70
			3.2 × 350	70 – 120

Suggested heat input is max. 1.5 kJ/mm and interpass temperature max. 100°C.

No preheating or post-weld heat treatment required.

## Approvals

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