

Classifications

EN ISO 14343-A	AWS A5.9 / SFA-5.9
S 20 25 5 Cu L	ER385

Characteristics and typical fields of application

Thermanit 20/25 Cu is a solid wire for submerged arc welding, stainless; resistant to intercrystalline corrosion and wet corrosion up to 350 °C. Good corrosion resistance similar to matching steels / cast steel grades, above all in reducing environment. For joining and surfacing work on matching austenitic CrNiMoCu steels/cast steel grades. Also for dissimilar joining these steels with unalloyed / low-alloy steels/cast steel grades.

Typical analysis of the wire

	C	Si	Mn	Cr	Ni	Mo	Cu
wt.-%	0.01	0.35	1.6	20.0	25.0	4.5	1.5

Typical fluxes to combine

Process	Name	EN ISO 14174
SAW	Marathon 104	S A FB 2 AC
SAW	Marathon 805 (Avesta Flux 805)	S A AF 2 DC

Packaging

Size(s) in mm	Type	Weight
2,4	basket spool	25 kg
3,2	basket spool	25 kg

Other sizes and coil weights on request.

