

Classifications

EN ISO 14343-A

S 25 4

Characteristics and typical fields of application

Solid wire for submerged arc welding. Corrosion resistance similar to matching or similar Mo-free 25% Cr(Ni) steels/cast steel grades. Resistant to scaling in air and oxidizing combustion gases up to 1150°C. Good resistance in sulfurous combustion gases at elevated temperatures.

Base materials

1.4347 GX8CrCrNiN26-7, 1.4340 GX49CrNi27-4, 1.4745 GX40CrSi23, 1.4746 X8CrTi25, 1.4762 X10CrAlSi25, 1.4776 GX40CrSi29, 1.4821 X15CrNiSi25-4, 1.4822 GX40CrNi24-5, 1.4823 GX40CrNiSi27-4
AISI 327, ASTM A297HC

Typical analysis

	C	Si	Mn	Cr	Ni	S	P
wt.-%	0.07	0.80	1.2	26.0	4.5	≤ 0.010	≤ 0.025

Operating data

Polarity

DC +/-

Dimension mm

2.0

Recommended SAW flux:

Marathon 431

Approvals

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