

4853 Kb

CATEGORY	SMAW Stick Electrodes
TYPE	Basic electrode for heat resistant stainless steel SMAW welding.
APPLICATIONS	Joining and cladding high heat resistant CrNi-steels of the same kind and Cast steels in a low sulphurous environment.
PROPERTIES	High corrosion resistance and excellent weldability on both AC and DC+. The weld deposit is scale resistant up to 1050°C

CLASSIFICATION	AWS EN ISO DIN: W.Nr. DIN	A 5.4: 14700: ~E Ni1 1600: EZ 25 35 Nb B 32 1.4853 8555: E 9-UM-200 RZ
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SUITABLE FOR	1.4852, 1.4853 G-X 40 NiCrNb 35 25, 1.4857, G-X 40 NiCrSi 35 25, 1.4837, G-X40CrNiSi25-12, 1.4848, G-X40CrNiSi25--20, 1.4849, G-X40NiCr38-18, G-X40NiCrNb35-25, cast steels, HK40, HK45, UNS: J93503, J94204, N08705
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APPROVALS	CE approved
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WELDING POSITIONS:



WELD DEPOSIT WEIGHT %	C	Mn	Si	Cr	Ni	Nb
	0.3-0.5	0.9-1.1	0.9	25-27	34-36	1.2-1.5

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	Rp0,2 (N/mm ²)	Rm (N/mm ²)	A5 (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				-20°C	-40°C	-60°C	
AW	>460	>690	>8				

AW: as welded

WELDING PARAMETERS PACKING

D (mm)	Welding Parameters			Packing		
	Length (mm)	Current (A)	kg / can	kg / 6pack	kg / 1000	
2.5	300	60-90	2.5	15	21	
3.2	350	80-110	2.8	16.8	39	
4.0	350	100-150	3.0	18	70	

REDRYING TEMPERATURE	300°C/2hr .
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