Selectarc 25/20B

High Temperature
Stainless Steel Electrode

Classification

AWS A5.4 : E310-15 EN 1600 : E 25 20 B 4 2
ISO 3581-A : E 25 20 B 4 2

Description & Applications

Basic coated electrode with an austenitic stainless steel deposit resisting to corrosion and oxidation up to 1200°C. Regular and stable fusion, good slag removal, nice aspect of the bead, resistant against hot cracks.

Main applications: Ovens, boilers, thermal equipments for heat treatment, chemical and petrochemical installations.

Base materials

Stainless and high temperature steels:

UNS	Alloy	EN	Material N°	UGINE
S31000	310	X15CrNiSi25-20	1.4841	
S31008	310S	X12CrNi25-21	1.4845	UGINOX R 25-20
S31400	314	X15CrNiSi25-20	1.4841	
S30900	309	X15CrNiSi20-12	1.4828	UGINOX R 20-12
		G-X15CrNi25-20	1.4840	
J93503		G-X40CrNiSi25-12	1.4837	
J94204	HK40	G-X40CrNiSi25-20	1.4848	

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	Mo	P	S	Cu	Fe
<0.12	0.5	2.2	25.5	20.5	0.2	0.03	0.02	0.2	Rem.

All Weld Metal Mechanical Properties

$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)	KV (J)
>380	>550	>30	+20°C >70

Welding Current & Instructions

Electrode	ØxL (mm)	2,0x300	2,5x300	3,2x350	4,0x350	5,0x450
Current	(A)	45	70	100	135	180

Redrying 2 hours at 250°C, if necessary. Avoid long stay at 600-850°C (sigma phase formation). Interpass temperature : < 150°C.

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