



# Selectarc 25/20R

High Temperature  
Stainless Steel Electrode

## Classification

AWS A5.4 : E310-16      EN 1600 : E 25 20 R 3 2  
ISO 3581-A : E 25 20 R 3 2

## Description & Applications

Rutile-basic electrode with a high temperature resistant austenitic stainless steel deposit. Resistant to corrosion and oxidation up to 1200°C, good resistance against hot cracks, easy slag removal and nice aspect of the weld beads.

**Main applications:** Construction of steam boilers, chemical installations, gas industry, ovens, thermal equipments.

### 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	Cu	P	S	O/T
0.10	0.75	2.0	25.5	20.5	0.45	0.15	0.020	0.010	<0.50

## All Weld Metal Mechanical Properties

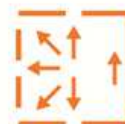
R <sub>p0.2</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )	KV ( J )
>400	>550	>30	+20°C >60

## 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 prolonged stay at 600-850°C (sigma phase formation).  
Interpass temperature : < 150°C

FT En-150-190225



= +	~ 70V
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