



Selectarc Inox 25/35H

High Temperature
Stainless Steel Electrode

Classification

ISO 3581-A : E Z 25 35 Nb H B 4 2

Description & Applications

Basic coated austenitic stainless steel electrode with 26%Cr, 35%Ni, 1.2%Nb and an increased carbon content. Used to weld austenitic heat resistant alloys, centrifugally cast tubes etc. resisting to scaling and oxidation up to 1200°C. Regular and stable fusion, good slag removal, nice aspect of the bead.

Main applications: Petrochemical industry, for welding centrifugally cast pyrolysis coils, reformer tubes, piping systems.

Base materials

UNS	Alloy	EN	Material N°
J93503		G-X40CrNiSi25-12	1.4837
J94204	HK40	G-X40CrNiSi25-20	1.4848
N08705	HP45	G-X40NiCrSi35-25	1.4857
		G-X40NiCr38-18	1.4849
		G-X40NiCrNb35-25	1.4852

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	Nb	Fe
0.4	1.2	1.6	26.0	35.0	1.2	Rem.

All Weld Metal Mechanical Properties

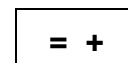
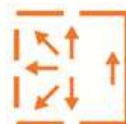
R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)
>440	>660	>12

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x300	3,2x350	4,0x350	5,0x350
Current	(A)	70	100	135	170

Redrying 2 hours at 250°C, if necessary. Interpass temperature : <150°C.

FT En-191-180420



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