

4850 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	A 5.4:
EN ISO	14700: E Ni1
	1600: EZ 21 32 Nb B 32
DIN: W.Nr.	1.4850
DIN	8555:

SUITABLE FOR

W.Nr:	DIN:	UNS:
1.4876	G-X10NiCrNb 32 20	N 08800
1.4861	X10NiCrAlTi 32 20	N 08810
1.4859	X5NiCrAlTi 31 20	N 08811
1.4958	X8NiCrAlTi 31 21	-
1.4959	-	Alloy 800H

APPROVALS CE approved

WELDING POSITIONS:

WELD DEPOSIT WEIGHT %

C	Si	Mn	Cr	Ni	Nb	Fe
0.12-0.18	0.3	4.5	21-23	32-35	0.9-1.2	Rem

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRC / HV
				20°C	-40°C	-60°C	
AW	380	600	25	50			

AW: as welded / minimum values at room temperature.

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	17.7	
3.2	350	80-110	2.8	16.8	35	
4.0	350	100-150	3.0	18	53	

REDRYING TEMPERATURE 300°C/2hr