

Classification : E 25 20 R 32 (ISO 3581-A/EN 1600) E 310-16 (AWS A5.4)

Properties :

Rutilo-basic electrode for welding stainless and refractory steels, depositing a refractory austenitic steel resistant to corrosion and oxidation up to 1200 degrees Celsius. Good resistance to hot cracking, very good welding behaviour, beautiful appearance of the cord, dairy easily detachable.

Applications :

Welding stainless steel 310, 310S, 314, 309, HK40, etc. Construction of steam boilers, furnaces, thermal appliances, in the oil industry, petrochemicals, etc.

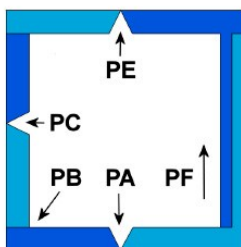
Mechanical caracteristics :

$R_{p0,2} > 400 \text{ MPa}$	$R_m = 550 \text{ MPa}$	$A_5D > 30 \%$	$KV > 60 \text{ J à } + 20 \text{ °C}$
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Packaging / Welding recommendations :

Ø mm	2,5	3,2	4
Poids étui (kg)	4	5	5
Intensité (A)	70	100	135

- Continuous current (electrode) or alternative (Uo - 70V).
- T° maximal between the passes: 150°C.
- Heating process: 2h at 250 °C if necessary.
- Avoid extended stays at 600 - 850oC (Sigma phase training).



Positions de soudage :

Responsibility: The purpose of this document is to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for the applications for which it is intended. We reserve the right to modify the characteristics of its products without notice. Descriptions, illustrations and features are provided as an indication and cannot be the responsibility of our company. Smoke: View information on the Security Data Sheet available on request