



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	Fe
0.1	0.9	2.0	25.5	20.5	Rem.

All Weld Metal Mechanical Properties

R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	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

ind.12



= + ~ 70V

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