



Selectarc Inox 25/4B

*Basic Coated Electrode
Heat Resistant Electrode*

Classification

ISO 3581-A : E 25 4 B 42

Mat. N° : 1.4820

Description & Applications

Basic coated electrode with a ferritic-austenitic deposit for heat resistant steels. Highly resistant alloy against reducing, oxidizing and sulphurous gases. Used at temperatures up to 1100°C in ovens and other heating equipment.

Main applications: Ovens, petrochemical industries...

Base materials:

Stainless steels for high temperature applications :

EN	Material N°
20CrNiSi25-4	1.4821
X40CrNiSi27-4	1.4823
X10CrAl7	1.4713
X10CrAl13	1.4724
X10CrAl18	1.4742
X10CrAl24	1.4762
X30CrSi6	1.4710
G-X40CrSi17	1.4740
G-X40CrSi23	1.4745
G-X40CrSi29	1.4776

Typical Weld Metal Composition (%)

C	Si	Mn	P	S	Cr	Ni	Mo	Cu	Fe
0.09	0.4	0.8	<0.025	<0.015	25.0	5.0	0.3	<0.1	Rem.

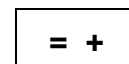
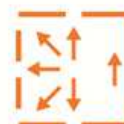
All Weld Metal Mechanical Properties

R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
520	700	18	+20°C 40

Welding Current & Instructions

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

Redrying 2h at 250°C, if necessary. Interpass temperature: 100-300°C



FT En-193-170926



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