

Classifications

EN ISO 14343-A
AWS A5.9 / SFA-5.9

S 25 22 2 N L

ER310 (mod.)

Characteristics and typical fields of application

Solid wire for submerged arc welding of high-alloyed corrosion resistant steel grades such as 1.4465 / UNS S31050. Solid wire of S 25 22 2 N L / ER310 (mod.) type for joining and surfacing applications with matching/similar steels. For weld cladding and for fabricating joints on claddings. Resistant to intercrystalline corrosion and wet corrosion up to 350°C. Good resistance to Cl-bearing environment, pitting corrosion and nitric acid. Especially for joining and surfacing applications in the equipment manufacturing for urea synthesis plants.

Typical analysis of the wire

	C	Si	Mn	Cr	Ni	Mo	N
wt.-%	0.01	0.10	6.0	25	22.5	2.2	0.12

Typical fluxes to combine

Process	Name	EN ISO 14174
SAW	Marathon 104	S A FB 2 AC

Packaging

Size(s) in mm	Type	Weight
3,0	basket spool	25 kg

Other sizes and coil weights on request.

