



25.35

W.N: *1.4853

EN ISO 14343-G/WZ 25 35 Zr

DESCRIPTION

Fully austenitic stainless steel filler metal characterized by high resistance to carburizing atmospheres and high resistance to temperature-scaling up to 1150°C. Excellent weldability on both AC and DC+. This grade may be used for high temperature applications; welding of heat-resistant steels and cast steels of similar nature; joining and overlay welding of similar alloyed heat resistant steels and steel casts; joining and cladding of high heat resistant Cr-Ni steels of the same kind and cast steels in a low sulphurous environment.

WELDING POSITIONS



POLARITY

Mig DC + / AC
Tig DC -

GAS

Mig Ar/Co2 (M12)
Tig Ar (I1)

BASE MATERIALS

1.4852

MECHANICAL PROPERTIES

<i>R_m</i> (Mpa)	<i>R_{p 0,2}</i> (Mpa)	<i>A₅</i> (%)	<i>KV(j)</i>
>600	>400	>8	

CHEMICAL ANALYSIS(%)

C	Mn	Si	Cr	Ni	Nb	Mo	Ti	Zr	
0,45	2,0	1,3	26,5	35,5	1,35	0,5	0,15	0,15	

PACKING INFORMATION AND WELDING PARAMETERS

Dimension Mig (mm)	0,8	1,0	1,2	
Spool (kg)	15	15	15	
Dimension Tig (mm)	1,6x1000	2,0x1000	2,4x1000	3,2x1000
Box (kg)	5	5	5	5

EQUIVALENT CONSUMABLES

MMA	Meltolit 25.35 E
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