



# Product Data Sheet

E 'Manual metal-arc welding'

OK 67.13

Prepared by A-C Thorsson	Qualified by Tero Tolonen	Approved by Tapio Huhtala	Reg no EN006118	Cancelling EN005466	Reg date 2013-06-12	Page 1 (2)
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## REASON FOR ISSUE

EN 1600 replaced by EN ISO 3581-A.

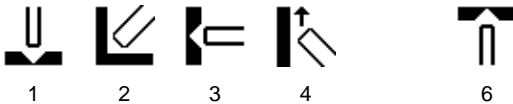
## GENERAL

Austenitic stainless steel electrode for welding 25Cr20Ni steels. The weld metal does not contain any measureable ferrite and resists scaling up to 1100-1150 °C.

**Min AC OCV:** 65  
**Polarity:** DC+, AC

**Alloy Type:** Austenitic CrNi  
**Coating Type:** Basic Rutile  
**Ferrite Content:** FN 0

## WELDING POSITIONS



## CLASSIFICATIONS Electrode

EN ISO 3581-A      E 25 20 R 1 2  
SFA/AWS A5.4      E310-16  
Werkstoffnummer    1.4842

## APPROVALS

Not applicable

## CHEMICAL COMPOSITION

### All Weld Metal (%)

	Min	Max
C	0.08	0.15
Si	0.20	0.70
Mn	1.4	2.5
P		0.025
S		0.020
Cr	25.0	27.0
Ni	20.0	22.0
Mo		0.5
Cu		0.20

## MECHANICAL PROPERTIES OF WELD METAL

Properties	AWS	
	As welded	
	Min	Typ
Rp0.2 (MPa)	370	430
Rm (MPa)	560	600
A4 (%)	30	35
Z (%)	45	55
at 20°C (J)	47	90

## Comments:

Interpass temp. < 125 °C.  
Hardness: 185-215 HV.



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## ECONOMICS & CURRENT DATA

Dimension (mm) Ø x Length	Current (A)		W	η	N	B	H	T	U	Welding Positions
	Min	Max								
2.5 x 300	50	85	1.9	95	0.51	101	0.8	42	21	1,2,3,4,6
3.2 x 350	65	120	3.8	95	0.51	53	1.2	58	24	1,2,3,4,6
4.0 x 350	70	160	5.7	95	0.51	34	1.7	61	28	1,2,3,4,6
5.0 x 350	150	220	8.9	100	0.54	21	2.6	67	31	1,2,3

**W** = Weight (kg / 100 electrodes)

**η** = Efficiency (g weld metal x 100 / g core wire)

**N** = Effective value (kg weld metal / kg electrodes)

**B** = Changes (number of electrodes / kg weld metal)

**H** = Deposit rate at 90% of max current (kg weld metal / hour arc time)

**T** = Fusion time at 90% of max current (s / electrode)

**U** = Arc voltage (V)

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## OTHER DATA

Redrying: 250 °C, 2 h.

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