



# Product Data Sheet

E 'Manual metal-arc welding'

OK 67.15

Prepared by A-C Thorsson	Qualified by Tero Tolonen	Approved by Tapio Huhtala	Reg no EN006119	Cancelling EN005083	Reg date 2013-06-12	Page 1 (2)
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## REASON FOR ISSUE

EN 1600 replaced by EN ISO 3581-A.

## GENERAL

Basic coated MMA-electrode for welding 25Cr 20Ni-steels. Also suitable for welding armour steels, austenitic manganese steels and for joining of dissimilar steels.

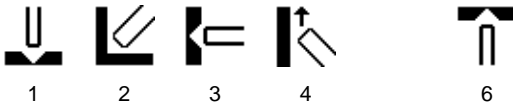
**Polarity:** DC+

**Alloy Type:** Austenitic CrNi

**Coating Type:** Lime Basic

**Ferrite Content:** FN 0

## WELDING POSITIONS



## CLASSIFICATIONS Electrode

EN ISO 3581-A    E 25 20 B 2 2  
SFA/AWS A5.4    E310-15  
Werkstoffnummer    1.4842

## APPROVALS

CE                    EN 13479  
DB                    30.039.01  
Seproz                UNA 272580  
VdTÜV                01025

## CHEMICAL COMPOSITION

### All Weld Metal (%)

	Min	Max
C	0.08	0.15
Si	0.20	0.70
Mn	1.80	2.50
P		0.025
S		0.020
Cr	25.0	27.0
Ni	20.0	22.0
Mo		0.50
Cu		0.50



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## MECHANICAL PROPERTIES OF WELD METAL

Properties	ISO		AWS
	Min	Typ	Min
As welded			As welded
Rp0.2 (MPa)	350	410	350
Rm (MPa)	560	590	560
A4 (%)			30
A5 (%)	27	35	
Z (%)		55	
at 20°C (J)	47	100	

### Comments:

Interpass temperature max. 150 °C.

Hardness weld metal HV 190 - 200.

## ECONOMICS & CURRENT DATA

Dimension (mm) Ø x Length	Current (A)		W	η	N	B	H	T	U	Welding Positions
	Min	Max								
2.0 x 300	45	55	1.2	105	0.62	162	0.6	36	24	1,2,3,4,6
2.5 x 300	50	85	1.7	105	0.61	96	0.9	40	25	1,2,3,4,6
3.2 x 350	60	115	3.4	105	0.59	50	1.2	60	25	1,2,3,4,6
4.0 x 350	70	160	4.7	100	0.59	28	1.8	62	26	1,2,3,4,6
5.0 x 350	130	200	7.5	100	0.60	22	2.5	65	26	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)

## OTHER DATA

Redrying: 200 °C, 2h