

1.4842 ML 25.20

## Stainless steel welding wires/rods

<b>Typical composition in %</b>	C..... 0,12 Si..... 0,40 Mn..... 1,80 P..... ≤ 0,025 S..... ≤ 0,015 Cr..... 26,0 Ni..... 20,7 Mo..... ≤ 0,5 Cu..... ≤ 0,4
<b>Classification</b>	DIN EN ISO 14343-A/G..... 25.20 Materialnumber..... 1.4842 AWS ER..... 310
<b>Base materials</b>	Claddings and joints on identical/similar heatresistant steels/steel castings.
<b>Resistance against corrosion</b>	Scale resisting up to 1.150° Celsius.
<b>Physical properties at 20° C (Approx. values)</b>	Yield strength $R_{p0,2}$ [MPa]..... 320 Tensile strength $R_m$ [MPa]..... 550 Elongation A [%]..... 25 Notched impact strength V [J]..... 80
<b>Shielding gas</b>	MIG: Ar+1-3% O <sub>2</sub> , Ar+1-3% CO <sub>2</sub> , Ar+He+O <sub>2</sub> , Ar+He+CO <sub>2</sub> , Ar+He+CO <sub>2</sub> +H <sub>2</sub> WIG: Ar, He, Ar+He, Ar+2-5% H <sub>2</sub>
<b>Polarity</b>	MIG =+, WIG =-
<b>Approvals</b>	none
<b>Dimensions Ø</b>	MIG-wires [mm]..... 0,8; 1,0; 1,2; 1,6 TIG-rods [mm]..... 1,0; 1,2; 1,6; 2,0; 2,4; 3,2; 4,0
<b>Wire packagings</b>	Spool types: BS 300 / 15 kg; Drum / 250 kg
<b>Rod packagings</b>	Box 5 kg / Length 1.000 mm