

1.4842 ML 25.20

Stainless steel welding wires/rods

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