

Classifications

EN ISO 14343-A

G 25 4

Characteristics and typical fields of application

GMAW wire for gas-shielded welding of heat resisting, analogous or similar steels. Ferritic-austenitic deposit. The low Ni-content renders this filler metal especially recommendable for applications involving the attack of sulphurous oxidizing or reducing combustion gases. Scaling resistance up to +1100 °C.

Base materials

Ferritic-austenitic

1.4821 X15CrNiSi25-4, 1.4823 GX40CrNiSi27-4

ferritic-perlitic

1.4713 X10CrAlSi7, 1.4724 X10CrAlSi13, 1.4742 X10CrAlSi18, 1.4762 X10CrAlSi25, 1.4710 GX30CrSi7, 1.4740 GX40CrSi17

AISI 327, ASTM A297HC

Typical analysis of solid wire (wt.-%)

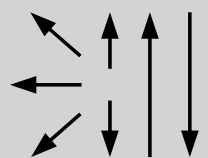
	C	Si	Mn	Cr	Ni
wt-%	0.07	0.8	1.2	25.7	4.5

Mechanical properties of all-weld metal

Condition	Yield strength R _e	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Impact work ISO-V KV J
	MPa	MPa	%	+20 °C
u	520 (≥ 450)	690 (≥ 650)	20 (≥ 15)	50

u untreated, as welded – shielding gas Ar + 2.5 % CO₂

Operating data

	Polarity: DC (+)	Shielding gases: Argon + max. 2.5 % CO ₂	ø (mm) 1.0 1.2
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Preheating and interpass temperature as required by the base metal.