

STELLOY 25-E

CLASSIFICATION

EN 14700 : E Z Co1

DESCRIPTION AND APPLICATIONS

- Rutile basic coated electrode
- Highly resistant to high temperature wear and metal-to-metal abrasion
- Particular ease of application due to its low cracking tendency
- Maintains a good level of hardness at high temperatures. Work-hardenable.
- Applications: straightening guides, vertical mill rolls and foot rolls in continuous casting
- Complements Welding Alloys cored wire STELLOY 25

TYPICAL ALL-WELD METAL ANALYSIS

C	Si	Mn	Cr	W	Fe	Mo	Ni	Co
0.10	0.80	1.00	20.0	15.0	2.00	5.00	10.0	Balance

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness as welded

220 HB

Hardness work-hardened

40 HRc

OPERATING CONDITIONS

Electrode ØxL [mm]	3.2x350	4.0x350
Current [A]	100	140

Redrying of the electrodes: 250°C/1h if necessary. Preheat massive pieces 250-400°C. Keep this temperature during welding, Cool down slowly after welding to reduce the risk of cracking while cooling.

= + ~ 70 V

WELDING POSITIONS

1G/PA, 2F/PB, 2G/PC

PACKAGING

Electrode ØxL [mm]	3.2x350	4.0x350
Weight/box [kg]	5	5

