MIG 25/35H

Classification

ISO 14343-A : G Z 25 35

Description & Applications

Solid wire for GMAW of heat resisting stainless steels with similar chemical composition like HP40. Very good resistance against pitting corrosion, oxidation and carburisation at range temperature of 900°C to 1100°C.

Main applications: Petrochemical industry, ovens, nuclear plant, heat treatment.

Base materials

Heat resisting stainless steels :

EN	*UNS*	*Nuances propriétaires*
1.4852	HP	Schmidt+Clemens : Centralloy G4852
1.4853	HP40	Duraloy : MO-RE 10 and 10MA
1.4857	HP40Cb	Doncasters Paralloy : H39W

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	Ti	Nb	Zr	P	S	Fe
Min												
Max						Not specified						
Type	0.42	1.1	1.8	26.0	35.0	0.30	0.10	1.3	0.10	0.015	0.003	Rem.

All Weld Metal Mechanical Properties*

	R_e (MPa)	R_m (MPa)	A_5 (%)	KV (J)	
Min	-	-	-	-	-
Max	-	-	-	-	-
Type	450	650	10	-	-

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Current (A)	Voltage (V)	
GMAW = +	0.8 1.0 1.2 1.6	70 - 180 80 - 220 150 - 320 220 - 380	18 - 26 18 - 28 22 - 32 24 - 34	ISO 14175: M12 (Ar+0.5-5%CO_2) M13 (Ar+0.5-3%O_2) 15-20 l/min

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