

Classifications

AWS A5.9 / SFA-5.9

EN ISO 14343-A

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S Z 22 17 8 4 N L

Characteristics and typical fields of application

Thermanit 20/16 SM is a solid wire of S Z 22 17 8 4 N L type for submerged arc welding. Resistant to saltwater and ductile at low temperatures. High resistance to intercrystalline corrosion and wet corrosion up to 350°C. Specially developed for joining and surfacing work on matching / similar non-magnetic CrNiMo(Mn,N) steels/cast steel grades.

Base materials

1.3948 – X4CrNiMnMoN19-13-8, 1.3951 – X2CrNiMoN22-15
 1.3952 – X2CrNiMoN18-14-3, 1.3953 – X2CrNiMo18-15
 1.3964 – X2CrNiMnMoNb21-16-5-3, 1.4439 – X2CrNiMoN17-13-5

Recommended SAW flux:

Marathon 104

Typical analysis

	C	Si	Mn	Cr	Ni	Mo	N
wt.-%	0.03	0.70	7.3	22.3	18.0	3.7	0.24

Structure: Austenite, no ferrite

Operating data

Dimension mm	Current A	Voltage V
2.4	300 – 400	29 – 33

Approvals

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