

Classifications

EN ISO 14343-A

G 25 4

Characteristics and typical fields of application

Solid wire of G 25 4 type for welding of heat resisting, matching or similar Mo-free 25Cr(Ni)-steels and cast steel grades. For parent metals susceptible to embrittlement, interpass temperature must not be allowed to exceed 300°C. Resistant to scaling in air and oxidizing combustion gases up to 1150°C. Good resistance in sulfurous combustion gases at elevated temperatures.

Base materials

1.4347 GX8CrCrNiN26-7, 1.4340 GX49CrNi27-4, 1.4745 GX40CrSi23, 1.4746 X8CrTi25, 1.4762 X10CrAlSi25, 1.4776 GX40CrSi29, 1.4821 X15CrNiSi25-4, 1.4822 GX40CrNi24-5, 1.4823 GX40CrNiSi27-4
AISI 327, ASTM A 297 HC

Typical analysis

	C	Si	Mn	Cr	Ni
wt.-%	0.06	0.8	0.8	26	5.0

Mechanical properties of all-weld metal - typical values (min. values)

Condition	Yield strength R _{p0.2}	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Hardness
	MPa	MPa	%	HB
u	≥ 500	≥ 650	≥ 20	180

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

Operating data

	Polarity	DC+	Dimension mm
	Shielding gas (EN ISO 14175)	M12 M13	

Preheating and interpass temperatures 200 – 400°C, depending on the relevant base metal and material thickness.

Shielding gas: Ar + 1 – 2% O₂ Ar + 2 – 3% CO₂

Approvals

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