

Classifications

EN ISO 14343-A

W 25 4

Characteristics and typical fields of application

TIG rod of W 25 4 type for welding of heat resisting, matching or similar Mo-free 25Cr(Ni)-steels and cast steel grades. The low Ni-content renders this filler metal especially recommendable for applications involving the attack of sulfurous oxidizing or reducing combustion gases.

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

Typical analysis

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

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

Condition	Yield strength $R_{p0.2}$	Tensile strength R_m	Elongation A ($L_0=5d_0$)	Impact energy ISO-V KV J
	MPa	MPa	%	20°C
u	540 (≥ 450)	710 (≥ 650)	22 (≥ 15)	70

u untreated, as-welded – shielding gas Ar

Operating data

	Polarity	DC-	Dimension mm
	Shielding gas (EN ISO 14175)	I1	2.4 × 1000
	Rod marking	+ W 25 4	

Preheating and interpass temperature as required by the base metal. For parent metals susceptible to embrittlement, interpass temperature must not be allowed to exceed 300°C.

Approvals

-