

25.35

Comparable specifications*

EN ISO 14343-A: G Z 25 35 Zr / W Z 25 35 Zr

* There are no national specifications for this alloy, neither ASME IX qualification F-number.

Werkstoff Nr.: ~ 1.4853

Description and applications*

* Illustrative, not-exhaustive list

Austenitic stainless steel filler metal characterized by high corrosion resistance and high resistance to temperature-scaling up to 1150°C. Excellent weldability on both AC and DC+.

This grade may be used for:

- high temperature applications;
- welding of high temperature cast steels with high carbon content;
- joining and overlay weldings of similar alloyed heat resistant steels and steel casts;
- fusion welding and cladding of high heat resistant Cr-Ni steels of the same kind and cast steels in a low sulphurous environment.

Weldable base materials*

* Illustrative, not-exhaustive list

W. Nr. 1.4852

All-weld metal mech. properties*

* For reference only values

Tensile strength (Rm): $\geq 600 \text{ N/mm}^2$ Yield Strength (Rp_{0.2}): $\geq 400 \text{ N/mm}^2$
Elongation: $\geq 8\%$

Chemical composition*

* For reference only values

| C | Mn | Si | S | P | Ni | Cr | Mo | Nb | Ti | Zr |
|------|------|------|-------|-------|-------|-------|------|------|------|------|
| 0.40 | 1.50 | 0.90 | max | max | 34.50 | 25.50 | 0.20 | 1.20 | 0.05 | 0.07 |
| 0.45 | 2.0 | 1.30 | 0.010 | 0.015 | 35.50 | 26.50 | 0.50 | 1.35 | 0.15 | 0.15 |

Standard packaging data*

| Welding process | Product type | Ø mm (inches) | Packing type | Weight kg (lbs) | Length mm (inches) |
|-----------------|--------------------------|-----------------------------|-------------------------|-------------------------|---------------------|
| GMAW ** | filler wire | 0.80 - 1.20 (0.030 - 0.047) | spools BS300 / D300 | 15 (33) | n.a. |
| GTAW ** | filler rod | 1.60 - 4.00 (1/16 - 5/32) | cardboard boxes / tubes | 5 (11) | 1000 (39.4) |
| SAW ** | filler wire | 1.60 - 4.00 (1/16 - 5/32) | basket rims B450 | 25 (55) | n.a. |
| SMAW ** | core wire for electrodes | 1.60 - 5.00 (1/16 - 0.197) | wooden boxes | 500 - 750 (1100 - 1650) | 250 - 450 (10 - 18) |

* Other sizes and packing types are available upon request

** GMAW: gas metal arc welding; GTAW: gas tungsten arc welding; SAW: submerged arc welding; SMAW: shielded metal arc welding

Marking

Each filler rod for GTAW welding is durably marked with an identification traceable to the unique product type. Welding filler materials wound on spools or in coils are durably marked on the coil or spool with an identification traceable to the unique product type.

The outside of each unit package is suitably labelled with at minimum the following data: grade, diameter, heat, lot no., classifications.

Customized labels are available upon request.

Lot classification

All our productions fulfil the **Class S3** requirements acc. to EN ISO 14344.