

## Classifications

EN ISO 3581-A	Mat. No.
E Z 25 22 2 N L B 2 2	≈1.4465

## Characteristics and typical fields of application

Stainless; resistant to intercrystalline corrosion – wet corrosion up to 350 °C (662 °F). Good resistance to Cl-bearing environments, pitting corrosion and nitric acid. Huey test to ASTM A262-64: 1.5 µ/48 h max., (0.25 g/m<sup>2</sup>h), selective attack 100 µ max. Particularly suited to corrosion conditions in urea synthesis plants. For joining and surfacing applications with matching / similar steels. For weld cladding on high temperature steels and for fabricating joints on claddings.

## Base materials

TÜV certified parent metals

1.4435 – X2CrNiMo18-14-3;

1.4466 – X2CrNiMoN25-22-2

1.4465 – X2CrNiMoN25-25;

## Typical analysis of all-weld metal (wt.-%)

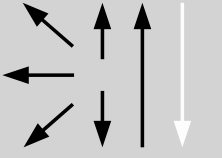
	C	Si	Mn	Cr	Mo	Ni	N
wt-%	< 0.035	< 0.4	5.0	24.5	2.2	22.0	0.15

**Structure:** Austenite, max. ferrite content 0.5 %

## Mechanical properties of all-weld metal

Heat-treatment	Yield strength R <sub>p0.2</sub>	Yield strength R <sub>p1.0</sub>	Tensile strength R <sub>m</sub>	Elongation A (L <sub>0</sub> =5d <sub>0</sub> )	Impact work ISO-V KV J
	MPa	MPa	MPa	%	+20 °C
aw	400	430	600	30	80

## Operating data

	Polarity: DC ( + )	ø (mm)	L mm	Amps A
		2.5	300	55 – 80
		3.2	350	80 – 105
		4.0	350	90 – 135

## Welding instruction

Materials	Preheating	Post-weld heat treatment
Matching / similar steels	None	None

## Approvals

TÜV (04171), CE