

Classifications					
EN ISO 14343-A		AWS A5.9		Mat. No.	
G 25 20 H		ER310(mod.)		1.4846	
Characteristics and typical fields of application					
Resistant to scaling up to 1000 °C (1832 °F).					
For surfacing and joining applications on matching heatresistant cast steel grades.					
Base materials					
1.4826 – GX40CrNiSi22-9					
1.4837 – GX40CrNiSi25-12					
1.4848 – GX40CrNiSi25-20					
Typical analysis of solid wire (wt.-%)					
	C	Si	Mn	Cr	Ni
wt-%	0.45	1.0	1.5	26.0	21.8
Structure: Austenite					
Mechanical properties of all-weld metal					
Heat-treatment	Yield strength R _{p0.2}	Yield strength R _{p1.0}	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	
	MPa	MPa	MPa	%	
aw	400	450	600	10	
Creep rupture properties: In the range of matching cast steel grades					
Operating data					
Polarity: DC (+)	Shielding gas: (EN ISO 14175) M13, M12		ø (mm) 1.2 1.6	Spool: B300 B300	
Welding instruction					
Materials		Preheating		Postweld heat treatment	
Matching heat resistant cast steel grades		None		None	