EZ - KROM 70

CLASSIFICATION

EN ISO 3581-A	AWS / ASME SFA-5.4
E 25 20 B 22	E310-15

DESCRIPTION AND APPLICATION

A Basic coated electrode for welding and surfacing heat resistant steels of 25/20 Cr-Ni type, ferrite-perlite Cr, Cr-Si and Cr-Al steels and heat resisting steel cast. Weld metal is austenite Cr-Ni type, resistant up to 1200°C.

Steel grade	HRN	DIN (W. Nr.)	ASTM / AISI	EN / ISO
High alloy heat resistant steels	Č 4578	X15 CrNiSi 25 20 (1.4841)	310 / 314	X15CrNiSi25-21
	-	X12 CrNi 25 21 (1.4845)	310 S	X8CrNi25-21
	-	G-X15 CrNi 25 20 (1.4840)	-	GX15CrNi25-20
	-	X7 CrNi 23 14 (1.4833)	-	X12CrNi23-13
	Č 4586	X20 CrNiSi 25 4 (1.4821)	327	X15CrNiSi25-4
	-	G-X 40 CrNiSi 22 9 (1.4826)	-	GX40CrNiSi22-9
	-	G-X 25 CrNiSi 20 14 (1.4832)	-	GX25CrNiSi20-14
	ČL 4577	G-X 40 CrNiSi 25 12 (1.4837)	-	GX40CrNiSi25-12

MECHANICAL PROPERTIES OF THE ALL-WELD METAL

$R_{p0,2}$ N/mm²	R_m N/mm²	A_5 %	KV (-40°C) J
> 350	> 550	> 20	> 47

APPROXIMATE CHEMICAL COMPOSITION OF THE ALL-WELD METAL

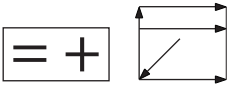
	C	Mn	Si	Cr	Ni
%	0,12	2,5	1,0	25,0	20,0

RECOMMENDED WELDING CURRENT

Ø mm	2,5	3,2	4,0	5,0
A	65 - 85	90 - 110	125 - 145	150 - 170

PACKAGING

Electrode dimensions mm	Quantity per ton approx. pieces	Weight of packaging kg
Ø 2,5 x 300	62 900	1,3
Ø 3,2 x 350	32 100	1,2
Ø 4,0 x 350	22 000	1,2
Ø 5,0 x 450	11 000	7,2



Marking: **E 310-15**
Dry before use 2h/300°C