

Stainless solid wire

Classification

EN 12072-99 : W 25 22 2 N L / G 25 22 2 N L

General description

Solid wire for welding high CrNiMo-alloyed austenitic steels of type 25/22/2
Excellent resistance to strong oxidizing and moderate reducing conditions
Especially for urea applications

Shielding gases (acc. EN 439)

GTAW	I1	Inert gas Ar (100%)
GMAW	M12	Mixed gas Ar+ >0-5% CO ₂
	M13	Mixed gas Ar+ >0-3% O ₂

Approvals

	TÜV
GTAW	+

Chemical composition (w%), typical, wire / rod

C	Mn	Si	Cr	Ni	Mo	N
0.018	5.0	0.4	25.0	23.0	2.0	0.15

Mechanical properties, typical, all weld metal

	Process	Shielding gas	Condition	0.2% Proof strength	Tensile strength	Elongation	Impact ISO-V(J)	
				(N/mm ²)	(N/mm ²)	(%)	+20°C	-10°C
Typical values	GTAW	I1	AW	360	620	30		80
	GMAW	M12	AW	360	620	30	80	

Materials to be welded

Steel grades	EN 10088-1/-2	W.Nr.	ASTM / ACl	UNS
Fully austenitic corrosion resistant	X1 CrNiMoN 25-25-2	1.4465		
	X3 CrNiMoTi 25-25	1.4577		
	X2 CrNi 19-11	1.4306	(TP)304L	S30403
CrNiMo-steel	X2 CrNiN 18-10	1.4311	CF-3	J92500
			(TP)304LN 310S	S30453 S31008

Also very well applicable for build-up welding on low alloyed steel, such as pipe plates
Buffer layer -120 ...+350°C

Packaging

Process	Unit	Sizes (mm)				
		0.8	1.0	1.2	2.0	2.4
GTAW	2 and 5 kg tube				X	X
GMAW	15 kg spool BS300	X	X	X		

Other sizes and packaging on request

LNT/LNM 4465: rev. EN 15