UTP 2133 Mn

basic coated CrNi stick electrode

Classifications	
EN ISO 3581-A	Material-No.
EZ 21 33 B 4 2	~ 1.4850

Characteristics and field of use

UTP 2133 Mn is suitable for joining and surfacing of heat-resistant steels and cast steels of the same orof similar nature, such as

1.4876	X10 NiCrAlTi 32 20	UNS N 08800
1.4859	G-X10 NiCrNb 32 20	
1.4958	X 5 NiCrAlTi 31 20	UNS N 08810
1.4959	X 8 NiCrAlTi 31 21	UNS N 08811

It is used for operating temperatures up to 1050° C in carburized low-sulphur combustion gas, e. g. in petrochemical plants.

Typical analysis in %

C	Si	Mn	Cr	Ni	Nb	Fe
0,14	0,5	4,5	21,0	33,0	1,3	balance

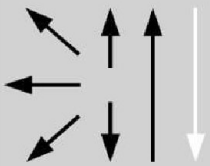
Mechanical properties of the weld metal

Yield strength $R_{P0,2}$	Tensile strength R_m	Elongation A	Impact strength K_V
MPa	MPa	%	J
> 410	> 600	> 25	> 50

Welding instruction

Hold stick electrode vertically with a short arc and lowest heat input. String beads are welded. The interpass temperature of 150° C should not be exceeded.
Redry stick electrodes for 2 – 3 h at 250 – 300° C.

Welding positions



Current type DC (+)

Approvals

TÜV (No. 07713)

Recommended welding parameters

Electrodes Ø x L [mm]	2,5 x 300	3,2 x 350	4,0 x 400
Amperage [A]	50 – 75	70 – 110	90 – 140