

Classifications

EN ISO 3581-A	Material-No.
EZ 25 35 Nb B 6 2	1.4853

Characteristics and field of use

UTP 2535 Nb is suitable for joining and surfacing of heat resistant CrNi-cast steels (centrifugal- and mouldcast parts) of the same or of similar nature, such as

1.4848	G-X 40 CrNiSi 25 20
1.4852	G-X 40 NiCrSiNb 35 26
1.4857	G-X 40 NiCrSi 35 26

It is used for operating temperatures up to 1150° C in carburized low-sulphur combustion gas, e. g. reforming ovens in petrochemical plants.

Typical analysis in %

C	Si	Mn	Cr	Ni	Nb	Ti	Fe
0,4	1,0	1,5	25,0	35,0	1,2	0,1	balance

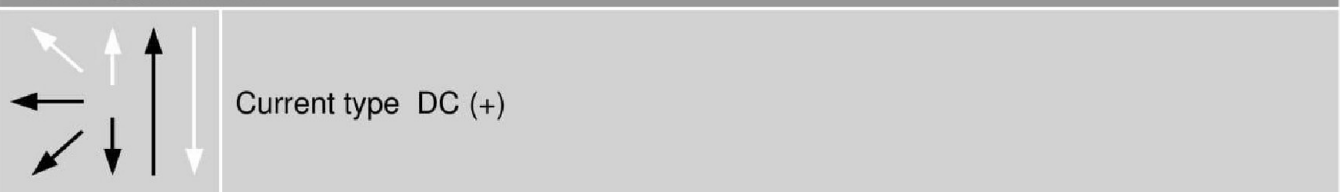
Mechanical properties of the weld metal

Yield strength $R_{P0,2}$	Tensile strength R_m	Elongation A
MPa	MPa	%
> 480	> 700	> 8

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 hours at 250 – 300° C

Welding positions



Recommended welding parameters

Electrodes $\varnothing \times L$ [mm]	2,5 x 300	3,2 x 350	4,0 x 400	5,0 x 400
Amperage [A]	50 – 70	70 – 120	100 – 140	

