

UTP A 2133 Mn

Standards :

Material-No. : ~ I.4850
EN ISO 14343 : W/GZ 21 33 Mn Nb

Fully austenitic welding wire for high temperature materials

Application field

UTP A 2133 Mn is suitable for joining and surfacing heat resistant base materials of identical and of similar nature, such as

I.4859	G X 10 NiCrNb 32 20	
I.4876	X 10 NiCrAlTi 32 21	UNS N08800
I.4958	X 5 NiCrAlTi 31 20	UNS N08810
I.4959	X 8 NiCrAlTi 31 21	UNS N08811

A typical application is the root welding of centrifugally cast pipes in the petrochemical industry for operation temperatures up to 1050° C in dependence with the atmosphere.

Properties of the weld metal

Scale resistant up to 1050°C. Good resistance to carburising atmosphere.

Mechanical properties of the weld metal

Yield strength R _{p0,2} MPa	Tensile strength R _m MPa	Elongation A %	Impact strength K _v Joule
> 400	> 600	> 25	> 70

Weld metal analysis in %

C	Si	Mn	Cr	Ni	Nb	Fe
0,12	0,3	4,5	21,0	33,0	1,2	balance

Welding instruction

Clean the weld area thoroughly. Low heat input. Max. interpass temperature 150°C

Welding procedure and availability

Ø (mm)	Current type	Shielding gas EN ISO 14175	Availability	
			Spools EN ISO 544	Rods L = 1000mm
0,8	DC (+)	x	x	
1,0	DC (+)	x	x	
1,2	DC (+)	x	x	
2,0	DC (-)	x		x
2,4	DC (-)	x		x
3,2	DC (-)	x		x

Approvals

TÜV (No. 10451)