

UTP A 2535 Nb

Standards :

Material-No. : 1.4853
 EN ISO 14343-A : G/WZ 25 35 Zr

Rods and wires for high temperature cast steels with high carbon content

Application field

UTP A 2535 Nb is suitable for joinings and building up on identical and similar high heat resistant CrNi cast steel (centrifugal- and mould cast parts), such as

1.4852 G-X 40 NiCrSiNb 35 25
 1.4857 G-X 40 NiCrSi 35 25

Properties of the weld metal

The weld deposit is applicable in a low sulphur, carbon enriching atmosphere up to 1150° C, such as reformer ovens in petrochemical installations.

Mechanical properties of the weld metal

Yield strength R _{p0,2} MPa	Tensile strength R _m MPa	Elongation A %
> 480	> 680	> 8

Weld metal analysis in %

C	Si	Mn	Cr	Ni	Nb	Ti	Zr	Fe
0,4	1,0	1,7	25,5	35,5	1,2	+	+	balance

Welding instructions

Clean welding area carefully. No pre heating or post weld heat treatment. Keep heat input as low as possible and interpass temperature at max. 180° C.

Welding procedure and availability

Ø (mm)	Current type	Shielding gas EN ISO 14175 	Availability	
			Spools EN ISO 544	Rods EN ISO 544
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