

Mill Test Certificate

E2535Nb Welding Rods

CATEGORY: Welding electrode to match 0.4%C-25%Cr-35%Ni-Nb heat resistant cast alloys, heat resistant.

DESCRIPTION: GTAW rod for joining and surfacing of heat resistant steels and cast steels of the same or similar chemical composition Resistant to scaling up to 1100°C. Typical alloy for welding of pyrolysis furnace tubes.

APPLICATIONS:

- Petrochemical Industry, - Reformer tubes, - Pyrolysis coils

CLASSIFICATION:

AWS A 5.4 25-35Nb | EN ISO: EN 12072: 1999:W Z25 35 Nb | DIN: W.No.: 1.4853

WELDING POSITIONS:



TYPICAL WELD DEPOSIT WEIGHT % :

Dia (MM)	Chemical Composition (%)								
	C	Si	Mn	Cr	S	Ni	Nb	Ti	Fe
3.2 x 350MM	0.3~0.5	0.2~1.3	0.5~1.9	23~27	0.014	32~36	0.75~1.5	0.02 ~ 0.20	Bal.
	Melting metal mechanical performance								
	RP0,2 (N/mm ²)	Rm (N/mm ²)	A5 %	Impact Energy (J) ISO-V			Hardness HRc / HV		
>460	>600	>8	-20°C -40°C -60°C						

Quality Control Stamp:
Date: Nov-07,2019

