

Mill Test Certificate

2535Nb

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

DESCRIPTION:

Electrode for joining and surfacing of heat resistant steels & 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 (%)								
3.2 x 350MM	C	Si	Mn	Cr	S	Ni	Nb	Ti	Fe
	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.
	0.37	0.90	1.15	24.75	0.013	33.58	1.15	0.09	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℃ -40℃ -60℃						

Quality Control Stamp:

Date: April-23, 2020



The information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and TOKO Corporation expressly disclaims any liability incurred from any reliance thereon. Typical data and Test results for mechanical properties, deposit or electrode composition and other properties were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application.