

25-35Nb

CATEGORY GMAW-GTAW welding rods

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

APPLICATIONS Electrocut 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.

CLASSIFICATION
AWS A 5.4:
EN ISO EN 12072: 1999:W Z~1.4889
DIN: W.Nr. 1.4853

SUITABLE FOR Petrochemical Industry, - Reformer tube.

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
Date: April-23, 2020

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