

35-45Nb

CATEGORY GMAW-GTAW welding rods

TYPE Filler metal for heat resistant stainless steel with similar composition and high carbon content.

APPLICATIONS Joining and cladding high heat resistant NiCr-steels of the same kind and Cast steels in a low sulphurous invironment.

CLASSIFICATION

AWS	A 5.4:
EN ISO	14343-A: GZ 35 45 Nb
DIN: W.Nr.	~1.4889

SUITABLE FOR (centrifugal- and mould cast parts), such as G X-45NiCrNbSiTi 45 35.

APPROVALS CE approved

WELDING POSITIONS:



TYPICAL WELD DEPOSIT WEIGHT %

C	Mn	Si	Cr	Ni	Nb	Ti	Fe
0.42	0.8	1.4	35	45	1.1	0.09	Rem

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	Rp _{0.2} (N/mm ²)	Rm (N/mm ²)	A5 (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				-20°C	-40°C	-60°C	
AW	>460	>660	>8				

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters				Packing	
D (mm)	Current (A) (DC-)	spool type	spool type	kg / spool	kg / pallet
1,0	15-28	80-240	S-300	15	1080
1,2	15-29	100-300	S-300	15	1080

REDRYING TEMPERATURE not required

GAS ACCORDING EN 14175: I1



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