

25-35Nb

CATEGORY	GMAW-GTAW Solid wires
TYPE	Filler metal for heat resistant stainless steel with similar composition
APPLICATIONS	Joining and cladding high heat resistant CrNi-steels of the same kind and Cast steels in a low sulphurous environment.
PROPERTIES	Recommended for operating temperatures up to 1150° C in carburized low-sulphur combustion gas, e. g. reforming ovens in petrochemical plants.
CLASSIFICATION	AWS A 5.9: EN ISO 14343-A: G(Z) 25 35 Zr DIN: W.Nr. ~1.4853

SUITABLE FOR 1.4852, 1.4853, G-X 40 NiCrNb 35 25, 1.4857, G-X 40 NiCrSi 35 25, 1.4837, G-X40CrNiSi25-12, 1.4848, G-X40CrNiSi25--20, 1.4849, G-X40NiCr38-18, G-X40NiCrNb35-25, cast steels, HK40, HK45, UNS: J93503, J94204, N08705

APPROVALS CE approved

WELDING POSITIONS:



TYPICAL WELD DEPOSIT WEIGHT %

C	Mn	Si	Cr	Ni	Nb	Ti	Fe
0,45	1,7	1.1	25-27	34-36	1.2-1.5	-	Rem

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				-20°C	-40°C	-60°C	
AW	>460	>690	>8				

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V) (DC+)	Current (A)	spool type	kg / spool	kg / pallet
0.8	14-25	60-180	S-300 / Drum	15 / 250	1080 / 1000
1.0	15-29	100-225	S-300 / Drum	15 / 250	1080 / 1000
1.2	17-32	160-300	S-300 / Drum	15 / 250	1080 / 1000

REDRYING TEMPERATURE not required

GAS ACCORDING EN 14175: M12, M13