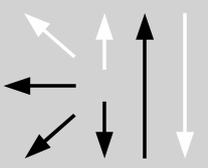


Classifications							
EN ISO 3581-A				Material-No.			
EZ 25 35 Nb B 6 2				1.4853			
Characteristics and field of use							
<p>UTP 2535 Nb is suitable for joining and surfacing of heat resistant CrNi-cast steels (centrifugal- and mouldcast parts) of the same or of similar nature, such as</p> <p>1.4848                    G-X 40 CrNiSi 25 20</p> <p>1.4852                    G-X 40 NiCrSiNb 35 26</p> <p>1.4857                    G-X 40 NiCrSi 35 26</p> <p>It is used for operating temperatures up to 1150° C in carburized low-sulphur combustion gas, e. g. reforming ovens in petrochemical plants.</p>							
Typical analysis in %							
C	Si	Mn	Cr	Ni	Nb	Ti	Fe
0,4	1,0	1,5	25,0	35,0	1,2	0,1	balance
Mechanical properties of the weld metal							
Yield strength $R_{P0,2}$			Tensile strength $R_m$			Elongation A	
MPa			MPa			%	
> 480			> 700			> 8	
Welding instruction							
<p>Hold stick electrode vertically with a short arc and lowest heat input. String beads are welded. The interpass temperature of 150° C should not be exceeded. Redry stick electrodes for 2 – 3 hours at 250 – 300° C</p>							
Welding positions							
		Current type DC (+)					
Recommended welding parameters							
Electrodes $\varnothing \times L$ [mm]	2,5 x 300	3,2 x 350	4,0 x 400	5,0 x 400			
Amperage [A]	50 – 70	70 – 120	100 – 140				