

Classifications

EN ISO 14172

E Ni Z (NiCr36Fe15Nb0,8)

Characteristics and typical fields of application

Resistant to scaling up to 1180 °C (2156 °F).

For surfacing and joining work on matching/similar heat resistant cast steel grades.

Base materials

GX45NiCrNbSiTi45-35

Typical analysis of all-weld metal (wt.-%)

	C	Si	Mn	Cr	Ni	Nb	Fe
wt-%	0.45	1.4	1.0	35.0	45.5	0.8	Bal.

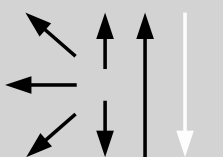
Structure: Austenite

Mechanical properties of all-weld metal

Heat-treatment	Yield strength $R_{p0.2}$	Tensile strength R_m	Elongation A ($L_0=5d_0$)
	MPa	MPa	%
aw	245	450	6

Creep rupture properties: In the range of matching cast steel grades

Operating data

	Polarity: DC (+)	ø (mm) 2.5	L mm 300	Amps A 55 – 80
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Welding instruction

Materials	Preheating	Postweld heat treatment
Matching / similar cast steel grades	None	None