

Classifications

EN ISO 18274

S Ni Z (NiCr36Fe15Nb0,8)

Characteristics and typical fields of application

Resistant to scaling up to 1180 °C (2156 °F). For joining and surfacing work on matching / similar heat resistant cast steel grades

Base materials

GX45NiCrSiNbTi45-35

Typical analysis of the TIG rods (wt.-%)

	C	Si	Mn	Cr	Ni	Nb
wt-%	0.42	1.5	1.0	35.0	45.5	0.8

Structure: Austenite

Mechanical properties of all-weld metal

Heattreatment	Yield strength R _{p0.2}	Tensile strength R _m
	MPa	MPa
aw	450	550

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

Operating data

Polarity:	Shielding gas:	Marks:	ø (mm)	L mm
DC (–)	(EN ISO 14175) I1	✦ 35 45 Nb / Ni 6701 mod.	1.6	1000
			2.0	1000
			2.4	1000
			3.2	1000

Welding instruction

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