



CEWELD 25-35Nb Tig

TYPE	Filler metal for heat resistant stainless steel with simmilar composition																		
APPLICATIONS	Joining and cladding high heat resistant CrNi-steels of the same kind and Cast steels in a low sulphourus environment.																		
PROPERTIES	Recommended for operating temperatures up to 1150° C in carburized low-Sulphur combustion gas, e. g. reforming ovens in petrochemical plants.																		
CLASSIFICATION	<table border="0"> <tr> <td>EN ISO</td> <td>14343-A: W Z 25 35Nb</td> </tr> <tr> <td>W.Nr.</td> <td>~1.4853</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>5</td> </tr> </table>	EN ISO	14343-A: W Z 25 35Nb	W.Nr.	~1.4853	F-nr	6	FM	5										
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SUITABLE FOR	1.4852, 1.4853, 1.4857, 1.4837, 1.4849, 1.4848 G-X40NiCrNb35-25, G-X40CrNiSi25-12, G-X40CrNiSi25-20, G-X40 NiCrSi35-25, G-X40NiCr38-18, G-X40NiCrNb35-25, cast steels, HK40, HK45, Incoloy 800H UNS: J93503, J94204, N08705 Manaurite 36X																		
APPROVALS																			
WELDING POSITIONS																			
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</th> <th>Cr</th> <th>Ni</th> <th>Nb</th> <th>Ti</th> </tr> </thead> <tbody> <tr> <td>0.4</td> <td>0.8</td> <td>1.7</td> <td>0.01</td> <td>0.01</td> <td>26</td> <td>35</td> <td>1.4</td> <td>0.1</td> </tr> </tbody> </table>	C	Si	Mn	P	S	Cr	Ni	Nb	Ti	0.4	0.8	1.7	0.01	0.01	26	35	1.4	0.1
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MECHANICAL PROPERTIES	<table border="1"> <thead> <tr> <th>Heat Treatment</th> <th>R_{P0,2} (MPa)</th> <th>R_m (MPa)</th> <th>A₅ (%)</th> <th>Hardness</th> </tr> </thead> <tbody> <tr> <td>As Welded</td> <td>480</td> <td>700</td> <td>8</td> <td>HRc</td> </tr> </tbody> </table>	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness	As Welded	480	700	8	HRc								
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As Welded	480	700	8	HRc															
REDRYING	Not required																		
GAS ACC. EN ISO 14175	I1																		



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25-35NB TIG 1,6 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663415950
25-35NB TIG 2,4 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663415967
25-35NB TIG 3,2 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663415974