

Classifications	
EN ISO 14343	Material-No.
GZ 25 35 Zr	1.4853

Characteristics and field of use
<p>UTP A 2535 Nb is suitable for joinings and building up on identical and similar high heat resistant CrNi cast steel (centrifugal- and mould cast parts), such as</p> <p>1.4848 G-X 40 CrNiSi 25 20 1.4852 G-X 40 NiCrSiNb 35 25 1.4857 G-X 40 NiCrSi 35 25</p> <p>The weld deposit is applicable in a low sulphur, carbon enriching atmosphere up to 1150 °C, such as reformer ovens in petrochemical installations.</p>

Typical analysis in %								
C	Si	Mn	Cr	Ni	Nb	Ti	Zr	Fe
0.4	1.0	1.7	25.5	35.5	1.2	+	+	balance

Mechanical properties of the weld metal		
Yield strength $R_{P0.2}$	Tensile strength R_m	Elongation A
MPa	MPa	%
> 480	> 680	> 8

Welding instruction
<p>Clean welding area carefully. No preheating or post weld heat treatment. Keep heat input as low as possible and interpass temperature at max. 150 °C.</p>

Wire diameter [mm]	Current type	Shielding gas (EN ISO 14175)
1.0	DC (+)	I 1
1.2	DC (+)	I 1