

## Classifications

EN ISO 3581-A	Material-No.
E Z 25 35 Nb B 6 2	1.4853

## Characteristics and typical fields of application

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

1.4848	G-X 40 CrNiSi 25 20
1.4852	G-X 40 NiCrSiNb 35 26
1.4857	G-X 40 NiCrSi 35 26

It is used for operating temperatures up to 1150° C in carburized low-sulphur combustion gas, e. g. reforming ovens in petrochemical plants.


## Typical analysis

	C	Si	Mn	Cr	Ni	Nb	Ti	Fe
wt.-%	0.4	1.0	1.5	25.0	35.0	1.2	0.1	bal.

## Mechanical properties of all-weld metal - typical values (min. values)

Yield strength $R_{p0.2}$	Tensile strength $R_m$	Elongation A ( $L_0=5d_0$ )
MPa	MPa	%
> 480	> 700	> 8

## Operating data

	Polarity	DC +	Dimension mm	Current A	
				2.5 × 300	50 – 70
				3.2 × 350	70 – 120
				4.0 × 400	100 – 140

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.

## Approvals

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