

UTP A 2133 Mn		nickel alloys				
Classifications		solid wire				
EN ISO 14343	Material-No.					
GZ 21 33 Mn Nb	~ 1.4850					
Characteristics and field of use						
<p>UTP A 2133 Mn is suitable for joining and surfacing heat resistant base materials of identical and of similar nature, such as</p> <p>1.4859 G X 10 NiCrNb 32 20 1.4876 X 10 NiCrAlTi 32 21 UNS N08800 1.4958 X 5 NiCrAlTi 31 20 UNS N08810 1.4959 X 8 NiCrAlTi 31 21 UNS N08811</p> <p>A typical application is the root welding of centrifugally cast pipes in the petrochemical industry for operation temperatures up to 1050 °C in dependence with the atmosphere.</p> <p>Scale resistant up to 1050 °C. Good resistance to carburising atmosphere.</p>						
Typical analysis in %						
C	Si	Mn	Cr	Ni	Nb	Fe
0.12	0.3	4.5	21.0	33.0	1.2	balance
Mechanical properties of the weld metal						
<i>Yield strength $R_{p0.2}$</i>	<i>Tensile strength R_m</i>	<i>Elongation A</i>		<i>Impact strength K_v</i>		
<i>MPa</i>	<i>MPa</i>	<i>%</i>		<i>J (RT)</i>		
400	600	20		70		
Form of delivery and recommended welding parameters						
<i>Wire diameter [mm]</i>	<i>Current type</i>		<i>Shielding gas (EN ISO 14175)</i>			
0.8	DC (+)		I 1			
1.0	DC (+)		I 1			
1.2	DC (+)		I 1			