

UTP A 2535 Nb		nickel alloys						
Classifications		solid wire						
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								
<i>Yield strength $R_{p0.2}$</i>		<i>Tensile strength R_m</i>		<i>Elongation A</i>				
<i>MPa</i>		<i>MPa</i>		<i>%</i>				
> 480		> 680		> 8				
Welding instructions								
Clean welding area carefully. No pre-heating or post weld heat treatment. Keep heat input as low as possible and interpass temperature at max. 150 °C.								
Form of delivery and recommended welding parameters								
<i>Wire diameter [mm]</i>		<i>Current type</i>		<i>Shielding gas (EN ISO 14175)</i>				
1.0		DC (+)		I 1				
1.2		DC (+)		I 1				