



# 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 invironment.                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                      |     |                         |                      |    |        |          |     |
| PROPERTIES                                        | Recommended for operating temperatures up to 1150° C in carburized low-Sulphur combustion gas, e. g. reforming ovens in petrochemical plants.                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                      |     |                         |                      |    |        |          |     |
| CLASSIFICATION                                    | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | 14343-A: W Z 25 35Nb |     |                         |                      |    |        |          |     |
|                                                   | W.Nr.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | ~1.4853              |     |                         |                      |    |        |          |     |
|                                                   | F-nr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | 6                    |     |                         |                      |    |        |          |     |
|                                                   | FM                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | 5                    |     |                         |                      |    |        |          |     |
| SUITABLE FOR                                      | 1.4852, 1.4853, 1.4857, 1.4837, 1.4849, 1.4848<br>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<br>UNS: J93503, J94204, N08705<br>Manaurite 36X                                                                                                                                                                                                                                                                                                                                            |                      |     |                         |                      |    |        |          |     |
| APPROVALS                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                      |     |                         |                      |    |        |          |     |
| WELDING POSITIONS                                 |        |                      |     |                         |                      |    |        |          |     |
| TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%) | 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 |
| MECHANICAL PROPERTIES                             | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                      |     | R <sub>P0,2</sub> (MPa) | R <sub>m</sub> (MPa) |    | A5 (%) | Hardness |     |
|                                                   | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                      |     | 480                     | 700                  |    | 8      | HRc      |     |
| REDRYING                                          | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                      |     |                         |                      |    |        |          |     |
| GAS ACC. EN ISO 14175                             | I1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                      |     |                         |                      |    |        |          |     |



# CEWELD 25-35Nb Tig

|                          |           |         |               |
|--------------------------|-----------|---------|---------------|
| 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 |