

25-35Nb Tig

CATEGORY GMAW-GTAW Solid wires

TYPE Filler metal for heat resistant stainless steel with similar composition

APPLICATIONS Joining and cladding high heat resistant CrNi-steels of the same kind and Cast steels in a low sulphurous environment.

CLASSIFICATION
 AWS A 5.9:
 EN ISO 14343-A: WZ 25 35 Zr
 DIN: W.Nr. ~1.4853

SUITABLE FOR 1.4852, 1.4853, G-X 40 NiCrNb 35 25, 1.4857, G-X 40 NiCrSi 35 25, 1.4837, G-X40CrNiSi25-12, 1.4848, G-X40CrNiSi25--20, 1.4849, G-X40NiCr38-18, G-X40NiCrNb35-25, cast steels, HK40, HK45, UNS: J93503, J94204, N08705

APPROVALS CE approved

WELDING POSITIONS:



TYPICAL WELD DEPOSIT WEIGHT %

C	Mn	Si	Cr	Ni	Nb	Ti	Fe
0.3-0.5	0.9-1.1	0.9	25-27	34-36	1.2-1.5	0.09	Rem

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				-20°C	-40°C	-60°C	
AW	>460	>690	>8				

AW: as welded

WELDING PARAMETERS / PACKING

D (mm)	Welding Parameters		Packing	
	Current (A) (DC-)		single	master
1.6 x 1000	50-80		5	25
2.4 x 1000	70-240		5	25

REDRYING TEMPERATURE not required

GAS ACCORDING EN 14175: I1