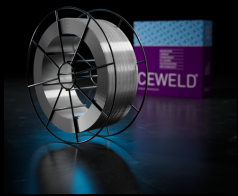


# CEWELD 25-35Nb

|                                                   |                                                                                                                                                                                                                                                                      |                         |                      |                    |          |      |
|---------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------|----------------------|--------------------|----------|------|
| 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: G Z 25-35 Nb   |                      |                    |          |      |
|                                                   | 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                                 | <div>PAPBPC</div> |                         |                      |                    |          |      |
| TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%) | C                                                                                                                                                                                                                                                                    | Si                      | Mn                   | Cr                 | Ni       | Nb   |
|                                                   | 0.045                                                                                                                                                                                                                                                                | 0.8                     | 1.7                  | 26                 | 35       | 0.22 |
| MECHANICAL PROPERTIES                             | Heat Treatment                                                                                                                                                                                                                                                       | R <sub>P0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Hardness |      |
|                                                   | As Welded                                                                                                                                                                                                                                                            | 460                     | 690                  | 8                  | HRc      |      |
| REDRYING                                          | Not required                                                                                                                                                                                                                                                         |                         |                      |                    |          |      |
| GAS ACC. EN ISO 14175                             | M13, M12                                                                                                                                                                                                                                                             |                         |                      |                    |          |      |



# CEWELD 25-35Nb

25-35NB 1,0MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663418463 |

25-35NB 1,2MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663415943 |