

Classifications

EN ISO 3581-A	Material-No.
E Z 21 33 B 4 2	~ 1.4850

Characteristics and typical fields of application

UTP 2133 Mn is suitable for joining and surfacing of heat-resistant steels and cast steels of the same or of similar nature, such as

1.4876	X10 NiCrAlTi 32 20	UNS	N 08800
1.4859	G-X10 NiCrNb 32 20		
1.4958	X 5 NiCrAlTi 31 20	UNS	N 08810
1.4959	X 8 NiCrAlTi 31 21	UNS	N 08811

It is used for operating temperatures up to 1050° C in carburized low-sulphur combustion gas, e. g. in petrochemical plants.

Typical analysis

	C	Si	Mn	Cr	Ni	Nb	Fe
wt.-%	0.14	0.5	4.5	21.0	33.0	1.3	bal.

Mechanical properties of all-weld metal - typical values (min. values)

Yield strength $R_{p0.2}$	Tensile strength R_m	Elongation A ($L_0=5d_0$)	Impact energy ISO-V KV J
MPa	MPa	%	
>410	>600	>25	>50

Operating data

	Polarity	DC +	Dimension mm	Current A
			2.5 × 300	50 – 75
			3.2 × 350	70 – 110
			4.0 × 350	90 – 140

Welding instructions

Hold stick electrode vertically with a short arc and lowest heat input. String beads are welded. The interpass temperature of 150° C should not be exceeded. Redry stick electrodes for 2 – 3 h at 250 – 300° C.

Approvals

TÜV (Nr. 07713)