

Classifications								
EN ISO 14343				Material-No.				
G Z 25 35 Zr				1.4853 (mod.)				
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</p> <p>1.4852 G-X 40 NiCrSiNb 35 25</p> <p>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								
Yield strength $R_{P0.2}$			Tensile strength R_m			Elongation A		
MPa			MPa			%		
> 480			> 680			> 8		
Welding instruction								
<p>Clean welding area carefully. No preheating or post weld heat treatment. Keep heat input as low as possible and interpass temperature at max. 150 °C.</p>								
Wire diameter [mm]			Current type			Shielding gas (EN ISO 14175)		
1.2			DC (+)			I 1		