



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 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 UNS: J93503, J94204, N08705 Manaurite 36X					
APPROVALS						
WELDING POSITIONS	 PA  PB  PC					
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 _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	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