



CEWELD 35-45Nb

TYPE Solid wire for heat-resistant cast stainless steels with a similar composition. (Type 3545, ~1.4889)

APPLICATIONS CEWELD 35-45 Nb is for joint and build-up welding on identical and similar, highly heat-resistant cast alloys (centrifugal casting, die casting), such as GX-45NiCrNbSiTi45 35. Mainly used for cast parts for reformer and pyrolysis furnaces.

PROPERTIES The weld metal of the CEWELD 35-45Nb can be used in a low-sulphur, carbon-enriching atmosphere up to 1175°C and has excellent creep resistance and good resistance to carburization and oxidation. No preheating or post heat treatment is necessary. Pay attention to low heat input and the interpass temperature should be limited to max. 150 °C.

CLASSIFICATION

AWS	18274: S Ni Z (NiCr36Fe15Nb0,8)
EN ISO	14343-A: G Z 35 45 Nb
W.Nr.	~1.4889

SUITABLE FOR 1.4898,
GX45NiCrNbSiTi45-35
Parralloy H46M, Centralloy ET45, Lloyds T80, Lloyds T75MA, Manaurite XT/XTM, E3545Nb-MA

APPROVALS CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Mn	Si	Ni	Cr	Mo	Cu	Nb	Ti	Al	Fe
	0.04	0.97	1.43	45.65	34.98	0.02	0.009	0.78	0.79	0.01	15.2

ALL WELD MECHANICAL PROPERTIES	Heat Treatment	R _{p0,2} MPa	R _m MPa	A5 (%)	
	As Welded /	460	600	10	

REDRYING TEMPERATURE Not required

GAS ACCORDING EN 14175 I1



CEWELD 35-45Nb

35-45NB 1,0MM

Type	KG/unit	EANCode
BS-300	15	8720663418494