


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 environment.												
PROPERTIES	Recommended for operating temperatures up to 1150° C in carburized low-sulphur combustion gas, e. g. reforming ovens in petrochemical plants.												
CLASSIFICATION	<table border="0"> <tr> <td>EN ISO</td> <td>14343-A: G Z 25-35 Nb</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>5</td> </tr> <tr> <td>W.Nr.</td> <td>~1.4853</td> </tr> </table>	EN ISO	14343-A: G Z 25-35 Nb	F-nr	6	FM	5	W.Nr.	~1.4853				
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F-nr	6												
FM	5												
W.Nr.	~1.4853												
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	No Approvals Found												
WELDING POSITIONS													
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>Cr</th> <th>Ni</th> <th>Nb</th> </tr> </thead> <tbody> <tr> <td>0.045</td> <td>0.8</td> <td>1.7</td> <td>26</td> <td>35</td> <td>0.22</td> </tr> </tbody> </table>	C	Si	Mn	Cr	Ni	Nb	0.045	0.8	1.7	26	35	0.22
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ALL WELD MECHANICAL PROPERTIES	<table border="1"> <thead> <tr> <th>Heat Treatment</th> <th>R_{p0,2} MPa</th> <th>R_m MPa</th> <th>A₅ (%)</th> </tr> </thead> <tbody> <tr> <td>As Welded /</td> <td>460</td> <td>690</td> <td>8</td> </tr> </tbody> </table>	Heat Treatment	R _{p0,2} MPa	R _m MPa	A ₅ (%)	As Welded /	460	690	8				
Heat Treatment	R _{p0,2} MPa	R _m MPa	A ₅ (%)										
As Welded /	460	690	8										
REDRYING TEMPERATURE	Not required												
GAS ACCORDING EN 14175	M13, M12												



CEWELD 25-35Nb

25-35NB 1,0MM

Type	KG/unit	EANCode
BS-300	15	8720663418463

25-35NB 1,2MM

Type	KG/unit	EANCode
BS-300	15	8720663415943