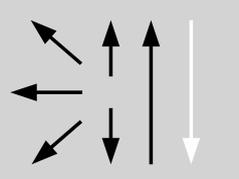


Classifications						
EN ISO 3581-A				Mat. No.		
E Z 25 35 Nb B 2 2				1.4853		
Characteristics and typical fields of application						
Resistant to scaling up to 1050 °C (1922 °F). For surfacing and joining work on matching / similar heat resistant cast steel grades.						
Base materials						
TÜV certified parent metal 1.4852 – GX40NiCrNb35-25						
Typical analysis of all-weld metal (wt.-%)						
	C	Si	Mn	Cr	Ni	Nb
wt-%	0.40	1.0	1.8	25.0	35.0	1.3
Structure: Austenite						
Mechanical properties of all-weld metal						
Heat-treatment	Yield strength R _{p0.2}	Yield strength R _{p1.0}	Tensile strength R _m	Elongation A (L ₀ =5d ₀)		
	MPa	MPa	MPa	%		
aw	400	450	600	8		
Operating data						
	Polarity: DC (+)	ø (mm)	L mm	Amps A		
		2.5	300	55 – 80		
		3.2	350	80 – 105		
		4.0	350	90 – 135		
Welding instruction						
Materials		Preheating	Postweld heat treatment			
Matching / similar cast steel grades		None	None			