



# Selectarc Inox 21/33Mn

High Temperature  
Stainless Steels Electrode

## Classification

ISO 3581-A : E Z 21 33 Mn Nb B 42

## Description & Applications

Basic coated austenitic stainless steel electrode with 21%Cr ,33%Ni, 1.2%Nb and an increased manganese content , used to weld austenitic heat resistant alloys, castings and plates resisting to scaling and oxidation up to 1050°C. Regular and stable fusion, good slag removal, nice aspect of the bead.

**Main applications:** Chemical and Petrochemical industries.

### Base materials

UNS	Alloy	EN	Material N°
N08800	800	X10NiCrAlTi32-20	1.4876
		G-X10NiCrNb32-20	1.4859
N08810		X5NiCrAlTi31-20	1.4958
N08811		X8NiCrAlTi32-21	1.4959

## Typical Weld Metal Composition ( % )

C	Si	Mn	Cr	Ni	Nb	Fe
0.12	0.5	4.5	21.0	33.0	1.0	Rem.

## All Weld Metal Mechanical Properties

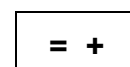
$R_{p0.2}$ ( MPa )	$R_m$ ( MPa )	$A_5$ ( % )
420	610	29

## Welding Current & Instructions

Electrode	ØxL ( mm )	2,5x300	3,2x350	4,0x350
Current	( A )	70	100	130

Redrying 2 hours at 250°C, if necessary. Interpass temperature : <150°C.

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