



TIG 35/45

Classification

ISO 18274 : S Ni Z Cr35Fe15Nb

Description & Applications

Solid rod for TIG welding matching high alloy heat resistant castings. Very good resistance to oxidation and carburisation at a range of service temperatures of ~1150°C.

Main applications: Ethylene pyrolysis coil, Tubes in petro-chemistry.

Base materials	EN	Proprietary Alloys
	1.4889	Schmidt+Clemens : Centralloy et45
	GX40NiCrNb45-35	Duraloy : MO-RE 40 AND 40MA
		Doncasters Paralloy : H46M

Typical Chemical Composition (%)

C	Si	Mn	Cr	Ni	Mo	Ti	Zr	Nb	Fe
0.42	1.5	1.0	35.0	45.5	0.1	0.1	0.1	0.8	Rem.

All Weld Metal Mechanical Properties

R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)
500	600	3

Welding Current & Instructions

Welding mode	Shielding Gas
TIG = -	Ar : 6-12 l/min Back shielding : Argon / Nitrogen : 3-6 l/min

FT En-T063M-1407

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