

Classifications

EN ISO 3581-A	Material-No.
EZ 25 35 Nb B 6 2	Special alloy

Characteristics and field of use

UTP 2535 NbLC is suitable for joining and surfacing of low-carbon high-temperature cast alloys (centrifugal- and mould cast parts) of the same or of similar nature.

A special application field is joining and assembling of tubes and casted form parts for pyrolysis and reformer ovens' outlet area, such as collectors, transfer circuits and quench pipes made of GX13NiCrNb37-25 (e.g. H 101).

The weld deposit can be used up to 1050°C and has a very good toughness and thermal shock resistance with sufficient creep strength and low tendency to embrittlement.

Typical analysis in %

C	Si	Mn	Cr	Ni	Nb	Fe
0,12	0,8	1,5	25,0	36,0	0,8	balance

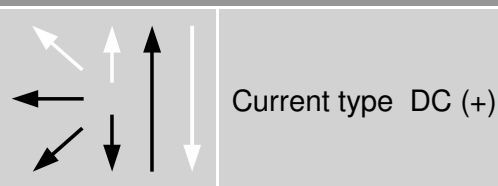
Mechanical properties of the weld metal

Yield strength $R_{P0,2}$	Tensile strength R_m	Elongation A
MPa	MPa	%
400	600	25

Welding instruction

Clean welding area thoroughly. Hold stick electrode vertically with a short arc and lowest heat input. String beads are welded. The interpass temperature of 150° C should not be exceeded. Redry stick electrodes for 2 – 3 hours at 250 – 300° C

Welding positions



Recommended welding parameters

Electrodes $\varnothing \times L$ [mm]	3,2 x 350
Amperage [A]	70 – 120