

**Classifications**

TIG rod

EN ISO 14343-A

Material-No.

WZ 25 35 Zr

1.4853

**Characteristics and field of use**

UTP A 2535 Nb is suitable for joinings and building up on identical and similar high heat resistant CrNi cast steel (centrifugal- and mould cast parts), such as

- 1.4848 G – X 40 CrNiSi 25 20
- 1.4852 G – X 40 NiCrSiNb 35 25
- 1.4857 G – X 40 NiCrSi 35 25

The weld deposit is applicable in a low sulphur, carbon enriching atmosphere up to 1150 °C, such as reformer ovens in petrochemical installations.

**Typical analysis in %**

C	Si	Mn	Cr	Ni	Nb	Ti	Zr	Fe
0.4	1.0	1.7	25.5	35.5	1.2	+	+	balance

**Mechanical properties of the weld metal**

Yield strength $R_{p0.2}$	Tensile strength $R_m$	Elongation $A$
MPa	MPa	%
> 480	> 680	> 8

**Welding instructions**

Clean welding area carefully. No pre-heating or post weld heat treatment. Keep heat input as low as possible and interpass temperature at max. 150 °C.

**Form of delivery and recommended welding parameters**

Rod diameter x length [mm]	Current type	Shielding gas (EN ISO 14175)
2.0 x 1000	DC (-)	I 1
2.4 x 1000	DC (-)	I 1
3.2 x 1000	DC (-)	I 1