Selectarc WELDING

TIG 25/35H

Classification

EN 14343A : WZ 25 35 Zr Material N° : 1.4853

Characteristics

GTAW is suitable for joinings and building up on identical and similar high heat resistant CrNi cast steel (centrifugal- and mould cast parts), such as1.4852 G–X 40 NiCrSiNb 35/25. Used to weld austhentic heat resistant alloys, centrifugally cast tubes etc. resisting to scaling and oxidation upto 1200°C.

Applications

Petrochemical Industry, Welding centrifugally cast pyrolysis coils, Reformer tubes, Piping systems.

Base materials

UNS	Alloy	EN	Material N°
J 93503	HK 40	G-X 40CrNiSi25-12	1.4837
J94204	HP 45	G-X40CrNiSi25-20	1.4848
N08705		G-X40NiCrNb35-25	1.4857

Typical Weld Metal Composition (%)

C	Si	Mn	Ni	Cr	Nb	S	P	Fe
0.40	1.10	1.00	35.50	25.60	1.25	0.010	0.010	base

All Weld Metal Mechanical Properties (Typical)

Conditions	UTS R_m (MPa)	YS $R_{p0.2}$ (MPa)	% Elg A_5
AW	725	500	20

Welding Current & Instructions

Welding Mode	Shielding Gas
TIG = -	Ar : 5 - 10 l/min Argon / He : 5 - 10 l/min

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