

Mill Test Certificate

25-35Nb GTAW Rods

CATEGORY: GTAW rod, high-alloyed, heat resistant

DESCRIPTION: GTAW rod for joining and surfacing of heat resistant steels and cast steels of the same or similar chemical composition Resistant to scaling up to 1100°C.

Typical alloy for welding of pyrolysis furnace tubes.

APPLICATIONS:

- Petrochemical Industry, - Reformer tubes, - Pyrolysis coils

CLASSIFICATION:

AWS A 5.4 25-35Nb | EN ISO: EN 12072: 1999:W Z25 35 Nb | DIN: W.No.: 1.4853

WELDING POSITIONS:



TYPICAL WELD DEPOSIT WEIGHT % :

Dia (mm)	Chemical Composition (%)								
	C	Si	Mn	Cr	S	Ni	Nb	Ti	Fe
1.2	0.3~0.5	1.2~1.3	1.7~1.9	25~27	0.014	34~36	1.2~1.5	0.09	Bal.
	Melting metal mechanical performance								
	RP0,2 (N/mm ²)	Rm (N/mm ²)	A5 %	Impact Energy (J) ISO-V			Hardness HRc / HV		
>460	>600	>8	-20°C -40°C -60°C						

Quality Control Stamp:
Date: Aug-17,2019

