

## Mill Test Certificate

### 2535Nb

**CATEGORY:** GMAW-GTAW Solid wires.

**TYPE:** A solid filler metal for joining and cladding heat resistant CrNi Steel of the same kind and cast steels. Such as 1.4848, 1.4852, 1.4857.

**APPLICATIONS:** Typical uses: for tubes and cast parts of pyrolysis furnaces. No pre-heating or post weld heat treatment needed.

**CLASSIFICATION:**

AWS A 5.9 2535Nb | EN ISO: 14343-A: WZ 25 35 | DIN: W.Nr. ~1.4853

**SUITABLE FOR:**

1.4852, 1.4853, G-X 40 NiCrNb 35 25, 1.4857, G-X 40 NiCrSi 35 25, 1.4837, G-X40CrNiSi25-12, 1.4848, G-X40CrNiSi25--20, 1.4849, G-X40NiCr38-18, G-X40NiCrNb35-25, cast steels, HK40, HK45, UNS: J93503, J94204, N08705

**WELDING POSITIONS:**



**TYPICAL WELD DEPOSIT WEIGHT % :**

Dia (mm)	Chemical Composition (%)								
	C	Si	Mn	Cr	S	Ni	Nb	Ti	Fe
	0.3~0.5	0.9~1.90	0.9~1.2	25~27	0.014	34~36	0.8~1.5	0.09	Remains
	0.37	0.97	0.95	25.60	0.013	34.80	1.10	0.08	Remains
1.2	Melting metal mechanical performance								
	RP0,2 (N/mm <sup>2</sup> )	Rm (N/mm <sup>2</sup> )	A5 %	Impact Energy (J) ISO-V			Hardness HRc / HV		
	>460	>690	>8	-20°C -40°C -60°C					

