

Mill Test Certificate

E2535Nb

CATEGORY: Welding Electrode to match 0.4%C-25%Cr-35%Ni-Nb heat resistant cast alloys, heat resistant.

DESCRIPTION: GTAW electrocute 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
3.2 x 350MM	0.3~0.5	0.2~1.3	0.5~1.9	23~27	0.014	32~36	0.75~1.5	0.02~0.20	Bal.
	0.37	0.90	1.15	24.75	0.013	33.58	1.15	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: April-23, 2020

