

CERTIFICATE OF QUALITY

25-35Nb

CATEGORY: GMAW-GTAW Solid wires.

TYPE: Filler metal for heat resistant stainless steel with similar composition.

APPLICATIONS:

Joining and cladding high heat resistant CrNi-steels of the same kind and Cast steels in a low sulphurous environment.

CLASSIFICATION:

AWS A 5.9 25-35Nb | EN ISO: 14343-A: WZ 25 35 Zr | 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
1.2	0.3~0.5	0.90	0.9~1.1	25~27	0.014	34~36	1.2~1.5	0.09	Rem
	Melting metal mechanical performance								
	RP0,2 (N/mm²)	Rm (N/mm²)	A5 %	Impact Energy (J) ISO-V			Hardness HRc / HV		
>460	>690	>8	-20°C -40°C -60°C						

Quality Control Stamp:

Date: March-17,2019

