

UTP 2535 Nb

Standards : Material-No. EN 1600

: I.4853 : EZ 25 35 Nb B 6 2

Basic coated stick electrode with high carbon content for cast steels

Application field

UTP 2535 Nb is suitable for joining and surfacing of heat resistant CrNi-cast steels (centrifugal- and mould cast parts) of the same or of similar nature, such as

I.4852	G–X 40 NiCrSiNb 35 26
I.4857	G–X 40 NiCrSi 35 26

Welding properties

It is used for operating temperatures up to 1100° C in carburized low-sulphur combustion gas, e.g. reforming ovens in petrochemical plants.

Mechanical properties of the weld metal

Yield strength	Tensile strength	Elongation
R _{p0,2}	R _m	Ā
MPa	MPa	%
> 480	> 700	> 8

Weld metal analysis in %

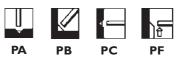
С	Si	Mn	Cr	Ni	Nb	Ti	Fe
0,4	1,0	١,5	25,0	35,0	١,2	0,1	balance

Welding instructions

Hold stick electrode vertically with a short arc and lowest heat input. String beads are welded. The interpass temperature of 150° C should not be exceeded. Re-dry stick electrodes for 2 - 3 hours at 250 - 300° C

Current type DC (+)

Welding positions



Availability / Current adjustment

Stick electrodes	Ø mm x L	2,5 x 300	3,2 x 350	4,0 x 400	5,0 x 400
Amperage	А	50-70	70-120	100-140	

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