

# UTP 2535 Nb

## Standards :

Material-No. : 1.4853  
 EN 1600 : 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

1.4852 G-X 40 NiCrSiNb 35 26  
 1.4857 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 $R_{p0,2}$ MPa	Tensile strength $R_m$ MPa	Elongation A %
> 480	> 700	> 8

## Weld metal analysis in %

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

## Welding instructions

Hold stick electrode vertically with a short arc and lowest heat input. String beads are welded. The inter-pass 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	A	50 - 70	70 - 120	100 - 140	