

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 <sub>p0,2</sub>	R <sub>m</sub>	Ā
MPa	MPa	%
> 480	> 700	> 8

#### Weld metal analysis in %

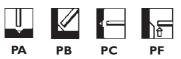
С	Si	Mn	Cr	Ni	Nb	Ti	Fe
0,4	1,0	١,5	25,0	35,0	١,2	0,1	balance

#### Welding instructions

Hold stick electrode vertically with a short arc and lowest heat input. String beads are welded. The interpass temperature of  $150^{\circ}$  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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