

35-45Nb Tig

CATEGORY GMAW-GTAW Solid wires

TYPE Filler metal for heat resistant stainless steel with similar composition and high carbon content.

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

PROPERTIES The weld deposit is applicable in a low sulphur, carbon enriching atmosphere up to 1175° C and has an excellent creep strength and a good resistance against carburization and oxidation.

CLASSIFICATION AWS A 5.9:
EN ISO 14343-A: W 35 45 Nb
DIN: W.Nr. ~1.4889

SUITABLE FOR (centrifugal- and mould cast parts), such as G X-45NiCrNbSiTi 45 35.

APPROVALS CE approved

WELDING POSITIONS: 

TYPICAL WELD DEPOSIT WEIGHT %

C	Mn	Si	Cr	Ni	Nb	Ti	Fe
0.42	0.8	1.4	35	45	1.1	0.09	Rem

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				-20°C	-40°C	-60°C	
AW	>460	>660	>8				

AW: as welded

WELDING PARAMETERS / PACKING

D (mm)	Welding Parameters	Packing	
	Current (A) (DC-)	single	master
1.6 x 1000	50-80	5	25
2.4 x 1000	70-240	5	25

REDRYING TEMPERATURE not required

GAS ACCORDING EN 14175: I1