

Alloy 33

CATEGORY GMAW-GTAW Solid wires

TYPE High-chromium austenitic alloy

APPLICATIONS Alloy 33 is a high-chromium austenitic alloy. This alloy combines ease of fabrication with outstanding resistance to highly oxidizing media

CLASSIFICATION DIN: W.Nr. 1.4591

APPROVALS CE approved

WELDING POSITIONS:



FILLER METAL ANALYSIS %

Ni	Cr	Fe	C	S	N	Mn	Si	Mo	Cu	P
30-33	31-35	Rem	0.015	0.010	0.35-0.6	2	0.5	0.5-2.0	0.3-1.2	0.02

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
				RT	-40°C	-60°C	
as welded	720	920	40				

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool	kg / pallet
1,2	28-32	180-220	S-300	15	1080

REDRYING TEMPERATURE not required

GAS ACC. EN ISO 14175: I1, Argon+Helium (70-30)