

2535 Nb

W.Nr. 1.4853

NIWIRE 2535 Nb is a solid filler metal for joining and cladding heat resistant CrNi steels of the same kind and cast steels, such as 1.4848, 1.4852, 1.4857.

Specification

AWS A5.9
EN ISO 14343-A: WZ 25 35
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Chemical Composition

Composition limits. 0.35-0.45 C; 2.0 max Mn; Bal. Fe; 0.04 max P; 0.04 max S; 2.0 max Si; 0.7-1.5 Nb; 32.0-37.0 Ni; 24.0-27.0 Cr

Applications

Typical uses: for tubes and cast parts of pyrolysis furnaces.

Mechanical Properties

Tensile Strength: 620 MPa Min
Yield Strength: 390 MPa Min
Elongation: 8% Min

Standard Packaging

TIG 11 lbs (5kgs) per tube
MIG 33 lbs (15kgs) per spool

Welding Procedure

No pre-heating or post weld heat treatment needed.

Ø (mm)	Current	Shielding gas
1.2	DC (+)	(EN ISO 14175)
2.0	DC (-)	
2.4	DC (-)	
3.2	DC (-)	