

3545 Nb

W.Nr. 1.4889

NIWIRE 3545 Nb is with high carbon content, used for MIG, TIG welding and surfacing work on similar heat resistant cast steel grades, such as GX40NiCrNb45-35

Specification

AWS A5.9
EN ISO 14343-A: GZ 35 45 Nb
W.Nr. 1.4889

Chemical Composition

Composition limits. 0.4-0.5 C; 1.0 max Mn; Bal. Fe; 0.02 max P; 0.03 max S; 1.5-2.0 Si; 1.0-1.5 Nb; 44.0-46.0 Ni; 34.0-36.0 Cr

Applications

Typical uses: for tubes and cast parts of reformer and pyrolysis ovens.

Mechanical Properties

Tensile Strength: 600 MPa Min
Yield Strength: 380 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 (-)	