

E2535 Nb

E2535 Nb

E2535 Nb is a coated electrode used for joining resistant cast alloys with 0.4%C-25%Cr-35%Ni-Nb (DIN 1.4852, 1.4853). It is also suitable for high carbon 18Cr/38Ni-Nb alloy such as DIN 1.4849.

It is used at temperatures up to 1100°C and is resistant to thermal shock and fatigue.

Specification

EN ISO 3581-A: EZ 25 35 Nb B 6 2

W.Nr. 1.4853

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: 400 MPa Min

Elongation: 8% Min

Welding Procedure

Redry stick electrodes for 2-3 hours at 250-300°C

∅ (mm)	Current
4.0x400	DC (+) 100-140A
5.0x400	DC (+)