

Classifications

EN ISO 14343-A	Material-No.
WZ 25 35 Zr	1.4853

Characteristics and field of use

TOKO 2535 Nb is suitable for joinings and building up on identical and similar high heat resistant CrNi cast steel (centrifugal- and mould cast parts), such as

1.4848	G-X 40 CrNiSi 25 20
1.4852	G-X 40 NiCrSiNb 35 25
1.4857	G-X 40 NiCrSi 35 25

The weld deposit is applicable in a low sulphur, carbon enriching atmosphere up to 1150° C, such as reformer ovens in petrochemical installations.

Typical analysis in %

C	Si	Mn	Cr	Ni	Nb	Ti	Zr	Fe
0,4	1,0	1,7	25,5	35,5	1,2	+	+	balance

Mechanical properties of the weld metal

Yield strength $R_{P0,2}$	Tensile strength R_m	Elongation A
MPa	MPa	%
> 480	> 680	> 8

Welding instruction

Clean welding area carefully. No preheating or post weld heat treatment. Keep heat input as low as possible and interpass temperature at max. 150° C.

Rod diameter x length [mm]	Current type	Shielding gas (EN ISO 14175)
2.0 x 1000	DC (-)	I 1
2.4 x 1000	DC (-)	I 1
3.2 x 1000	DC (-)	I 1