

# 35-45Nb

**CATEGORY** GMAW-GTAW Solid wires

**TYPE** Filler metal for heat resistant stainless steel with similar composition and high carbon content.

**APPLICATIONS** Joining and cladding high heat resistant NiCr-steels of the same kind and Cast steels in a low sulphurous environment.

**CLASSIFICATION** AWS A 5.9:  
EN ISO 14343-A: GZ 35 45 Nb  
DIN: W.Nr. ~1.4889

**SUITABLE FOR** (centrifugal- and mould cast parts), such as G X-45NiCrNbSiTi 45 35.

**APPROVALS** CE approved

**WELDING POSITIONS:** 

## TYPICAL WELD DEPOSIT WEIGHT %

C	Mn	Si	Cr	Ni	Nb	Ti	Fe
0.42	0.8	1.4	35	45	1.1	0.09	Rem

## ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				-20°C	-40°C	-60°C	
AW	>460	>660	>8				

AW: as welded

## WELDING PARAMETERS / PACKING

D (mm)	Welding Parameters		Packing		
	Current (A) (DC-)	spool type	spool type	kg / spool	kg / pallet
1,0	15-28	80-240	S-300	15	1080
1,2	15-29	100-300	S-300	15	1080

**REDRYING TEMPERATURE** not required

**GAS ACCORDING EN 14175:** I1