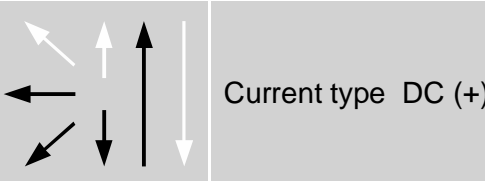


Basic-coated special stick electrode for high-temperature cast alloys with high carbon content in the petrochemical industry

Classifications						
EN ISO 14172						
E Ni Z 6701 (NiCr36Fe15Nb0.8)						
Characteristics and field of use						
UTP 3545 Nb is suitable for joining and surfacing on identical and similar high-heat-resistant cast alloys (centrifugal- and mould cast parts), such as G-X45NiCrNbSiTi45 35. The main application field is tubes and cast parts of reformer and pyrolysis ovens.						
Properties of the weld metal						
The weld deposit is used in low-sulphur, carburizing atmosphere up to 1,175°C.						
Typical analysis in %						
C	Si	Mn	Cr	Ni	Nb	Fe
0.45	1.0	0.8	35.0	45.0	0.9	balance
Mechanical properties of the weld metal						
Yield strength $R_{p0,2}$			Tensile strength R_m			
MPa			MPa			
480			680			
Welding instruction						
Clean weld area thoroughly. Weld the stick electrode with a slight tilt and a short arc. No pre-heating or post weld heat treatment required. Keep heat input as low as possible and interpass temperature of max. 150°C. Re-baking: 2 - 3 hours at 250 – 300°C.						
Welding positions						
						
Recommended welding parameters						
Electrodes $\varnothing \times L$ [mm]	2.5 x 300		3.2 x 350		4.0 x 350	
Amperage [A]	70 – 90		90 – 110		100 – 140	