

Classifications

EN ISO 14343	Material-No.
WZ 21 33 Mn Nb	~ 1.4850

Characteristics and field of use

UTP A 2133 Mn is suitable for joining and surfacing heat resistant base materials of identical and of similar nature, such as

1.4859	G X 10 NiCrNb 32 20
1.4876	X 10 NiCrAlTi 32 21 UNS N08800
1.4958	X 5 NiCrAlTi 31 20 UNS N08810
1.4959	X 8 NiCrAlTi 31 21 UNS N08811

A typical application is the root welding of centrifugally cast pipes in the petrochemical industry for operation temperatures up to 1050° C in dependence with the atmosphere.

Scale resistant up to 1050° C. Good resistance to carburising atmosphere.

Typical analysis in %

C	Si	Mn	Cr	Ni	Nb	Fe
0,12	0,3	4,5	21,0	33,0	1,2	balance

Mechanical properties of the weld metal

Yield strength R _{P0,2}	Tensile strength R _m	Elongation A	Impact strength K _v
MPa	MPa	%	J [RT]
400	600	20	70

Welding instruction

Clean the weld area thoroughly. Low heat input. Max. interpass temperature 150° C.

Approvals

TÜV (No. 10451)

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