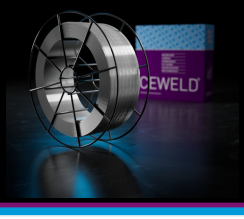


CEWELD 21-33Mn

certilas® THE FILLER METAL SPECIALIST

TYPE

Filler metal for heat resistant stainless steel with simmilar nature and composition

APPLICATIONS

Joining and cladding high heat resistant CrNi-steels of the same kind and Cast steels in a low sulphourus invironment. Typical alloy for welding of pyrolysis furnace tubes.

PROPERTIES

Recommended for operating temperatures up to 1050°C in carburized invironments in ovens in petrochemical plants.

CLASSIFICATION

EN ISO	14343-A: G Z 21 33 Mn Nb
W.Nr.	1.4850 (mod)

SUITABLE FOR

1.4876, 1.4859, 1.4958, 1.4959,
X10NiCrAlTi32-21, GX10NiCrSiNb32-20, X5NiCrAlTi31-20, X8NiCrAlTi32-21, X 12 CrNiTi 18 9
UNS N08800, N08810, N08811
Alloy 800, Alloy 800H, Alloy 800HT, Manaurite 900, Nicrofer 3220 H

APPROVALS

CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Mn	Si	Cr	Ni	Nb	Fe
0.1	4.6	0.28	21.2	33.2	1.2	Rem.

MECHANICAL PROPERTIES

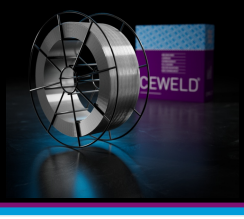
Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V	Hardness
				RT	
As Welded	410	620	21	82	HRc

REDRYING

Not required

GAS ACC. EN ISO 14175

I1, I3



CEWELD 21-33Mn

21-33MN 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663424273