

Classifications						
EN ISO 14343	Material-No.					
WZ 21 33 Mn Nb	~ 1.4850					
Characteristics and field of use						
<p>UTP A 2133 Mn is suitable for joining and surfacing heat resistant base materials of identical and of similar nature, such as</p> <p>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</p> <p>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.</p> <p>Scale resistant up to 1050° C. Good resistance to carburising atmosphere.</p>						
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		