



CEWELD 35-45Nb

TYPE Solid wire for heat-resistant cast stainless steels with a similar composition. (Type 3545, ~1.4889)

APPLICATIONS CEWELD 35-45 Nb is for joint and build-up welding on identical and similar, highly heat-resistant cast alloys (centrifugal casting, die casting), such as GX-45NiCrNbSiTi45 35. Mainly used for cast parts for reformer and pyrolysis furnaces.

PROPERTIES The weld metal of the CEWELD 35-45Nb can be used in a low-sulphur, carbon-enriching atmosphere up to 1175°C and has excellent creep resistance and good resistance to carburization and oxidation. No preheating or post heat treatment is necessary. Pay attention to low heat input and the interpass temperature should be limited to max. 150 °C.

CLASSIFICATION

AWS	636-A: S Ni Z (NiCr36Fe15Nb0,8)
EN ISO	14343-A: G Z 35 45 Nb
W.Nr.	~1.4889

SUITABLE FOR 1.4898,
GX45NiCrNbSiTi45-35
Parralloy H46M, Centralloy ET45, Lloyds T80, Lloyds T75MA, Manaurite XT/XTM, E3545Nb-MA

APPROVALS CE

WELDING POSITIONS

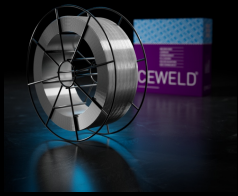


TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Mn	Si	Ni	Cr	Mo	Cu	Nb	Ti	Al	Fe
	0.04	0.97	1.43	45.65	34.98	0.02	0.009	0.78	0.79	0.01	15.2

MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness
	As Welded	460	600	10	HRc

REDRYING Not required

GAS ACC. EN ISO 14175 I1



CEWELD 35-45Nb

35-45NB 1,0MM

Packaging	KG/unit	EanCode
BS-300	15	8720663418494