



# CEWELD 21-33Mn

**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 sulphurous 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 <sub>P0.2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	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