



# CEWELD 21-33Mn

<b>TYPE</b>	Filler metal for heat resistant stainless steel with simmilar nature and composition
<b>TOEPASSINGEN</b>	Joining and cladding high heat resistant CrNi-steels of the same kind and Cast steels in a low sulphurous environment.
<b>EIGENSCHAPPEN</b>	Recommended for operating temperatures up to 1050°C in carburized invironments in ovens in petrochemical plants.
<b>CLASSIFICATIE</b>	EN ISO 14343-A: G Z 21 33 Mn Nb W.Nr. 1.4850 (mod)
<b>GESCHIKT VOOR</b>	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

**GOEDKEURINGEN** CE

**LASPOSITIES**



**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.

**MECHANISCHE WAARDEN**

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

**HERDROGEN** Not required

**GAS ACC. EN ISO 14175** I1, I3



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21-33MN 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663424273