

Classifications						
EN ISO 14343-A				Mat. No.		
W Z 25 35				1.4853		
Characteristics and typical fields of application						
Resistant to scaling up to 1050 °C (1922 °F). For joining and surfacing work with matching / similar heat resistant cast steel grades						
Base materials						
TÜV-certified parent metal 1.4852 – GX40NiCrSiNb35-25						
Typical analysis of the TIG rods (wt.-%)						
	C	Si	Mn	Cr	Ni	Nb
wt-%	0.42	1.0	1.8	26.0	35.0	1.3
Structure: Austenite						
Mechanical properties of all-weld metal						
Heat-treatment	Yield strength R _{p0.2}	Yield strength R _{p1.0}	Tensile strength R _m	Elongation A (L ₀ =5d ₀)		
	MPa	MPa	MPa	%		
aw	450	500	650	8		
Creep rupture properties: In the range of matching cast steel grades						
Operating data						
Polarity: DC (–)	Shielding gas: (EN ISO 14175) I1	Marks: ✦ 1.4853 / WZ 25 35		ø (mm)	L mm	
				2.0	1000	
				2.4	1000	
				3.2	1000	
Welding instruction						
Materials			Preheating	Postweld heat treatment		
Matching / similar cast steel grades			None	None		