



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 sulphourus 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 W.Nr.	14343-A: G Z 21 33 Mn Nb 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	PAPBPCPDPEPF						
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 _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardnes
	As Welded	410	620	21	RT		HRc
REDRYING	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