

Classifications						
EN ISO 14343-A				Mat. No.		
G 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 on matching / similar heat resistant cast steel grades.						
Base materials						
1.4852 – GX40NiCrSiNb35-25						
Typical analysis of solid wire (wt.-%)						
	C	Si	Mn	Cr	Ni	Nb
wt-%	0.42	1.2	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	400	450	600	8		
Creep rupture properties: In the range of matching cast steel grade						
Operating data						
Polarity: DC (+)	Shielding gas: (EN ISO 14175) M12, M13		ø (mm) 1.2	Spool: B300		
Welding instruction						
Materials			Preheating	Postweld heat treatment		
Matching / similar cast steel grades			None	None		