

Meltolit

21.33

W.N: *1.4850

EN ISO 14343-G/WZ 21 33 Mn Nb

DESCRIPTION

Fully austenitic stainless steel filler metal characterized by high resistance to carburizing atmospheres and high resistance to temperature-scaling up to 1050°C. Excellent weldability on both AC and DC+. This grade may be used for high temperature applications; welding of heat-resistant steels and cast steels of similar nature; joining and overlay welding of similar alloyed heat resistant steels and steel casts; joining and cladding of high heat resistant Cr-Ni steels of the same kind and cast steels in a low sulphureous environment.

WELDING POSITIONS



POLARITY

Mig DC + / AC
Tig DC -

GAS

Mig Ar/Co2 (M12)
Tig Ar (I1)

BASE MATERIALS

1.4876(Alloy 800), 1.4958(Alloy 800H), 1.4859, 1.4959

MECHANICAL PROPERTIES

<i>R_m</i> (Mpa)	<i>R_{p 0,2}</i> (Mpa)	<i>A5</i> (%)	<i>KV(j)</i>
>600	>380	>25	+20°C: >50

CHEMICAL ANALYSIS(%)

C	Mn	Si	Cr	Ni	Nb	Mo	Ti	Zr	Cu
0,17	5,0	0,3	22,0	33,0	1,3	<0,5	0,15-0,3	<0,05	<0,3

PACKING INFORMATION AND WELDING PARAMETERS

Dimension Mig (mm)	0,8	1,0	1,2	
Spool (kg)	15	15	15	
Dimension Tig (mm)	1,6x1000	2,0x1000	2,4x1000	3,2x1000
Box (kg)	5	5	5	5

EQUIVALENT CONSUMABLES

MMA	Meltolit 21.33 E
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