



Selectarc Inox 21/33Mn

High Temperature
Stainless Steels Electrode

Classification

ISO 3581-A : E Z 21 33 Mn Nb B 42

Description & Applications

Basic coated austenitic stainless steel electrode with 21%Cr ,33%Ni, 1.2%Nb and an increased manganese content , used to weld austenitic heat resistant alloys, castings and plates resisting to scaling and oxidation up to 1050°C. Regular and stable fusion, good slag removal, nice aspect of the bead.

Main applications: Chemical and Petrochemical industries.

Base materials

UNS	Alloy	EN	Material N°
N08800	800	X10NiCrAlTi32-20	1.4876
		G-X10NiCrNb32-20	1.4859
N08810		X5NiCrAlTi31-20	1.4958
N08811		X8NiCrAlTi32-21	1.4959

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	Nb	Fe
0.12	0.5	4.5	21.0	33.0	1.0	Rem.

All Weld Metal Mechanical Properties

R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)
420	610	29

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x300	3,2x350	4,0x350
Current	(A)	70	100	130

Redrying 2 hours at 250°C, if necessary. Interpass temperature : <150°C.

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