21.33.MnNb

TOP FEATURES

- Design for hot cracking resistance in highly restrained welds
- Optimum resistance to ageing embritlement

CLASSIFICATION

There are no national specifications for this electrode.

SHIELDING GASES (ACC. EN ISO 14175)

I1 Inert gas Ar (100%)

CHEMICAL COMPOSITION (WEIGHT %), WIRE

	C *	Mn	Si	S	P	Cr	Ni	Mo	Nb	Cu	Al	Ti
Min.	0.10	3.5				19.0	30.0		0.8			
Max.	0.20	5.0	0.70	0.015	0.025	23.0	35.0	0.50	1.5	0.5	0.35	0.30
Typical	0.15	4.3	0.5	0.008	0.012	21	33	0.3	1	0.1	0.1	0.15

* Weld deposit carbon is typically a little lower than wire analysis.

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

As welded		Min. *	Typical
Tensile strength	**(MPa)**	520	640
0.2% Proof strength	**(MPa)**	210	420
Elongation (%)	**4d**		27
	5d		25
Impact ISO-V (J)	**+20°C**		40

* Minimum tensile properties based on wrought alloy 800H.

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Weight (kg)	Item number
2.4	PE Tube	5.0	T2133MN-24

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:

Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.