

Standards:

EN ISO 3581-A: EZ 20 16 3 Mn 3 LR 32
 EN 1600: E 18 15 3 LR 23
 Mat.-No.: 1.4455

capilla® 4455

Product description:

Rutile-basic coated stick electrode suitable for welding of austenitic stainless steel grades. The deposit is nonmagnetic and has good properties at low temperatures.

Applications:

Cladding and fusion welding of similar alloyed cryogenic austenitic CrNi(N)- and CrNiMo(Mn,N)-steel grades; Also used for welding of cryogenic martensitic Ni-steels.

Typical weld metal composition:

[wt. - %]

	C	Si	Cr	Ni	Mo	Mn	N	Fe
Min.			18	14	2,6	2,5	0,1	
Max.	0,03	0,9	20	16,5	3	4	0,2	Bal.

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Tensile strength R_m :	640	[MPa]
Yield strength $R_{p0,2}$:	440	[MPa]
Yield strength $R_{p1,0}$:	-	[MPa]
Elongation (L=5d):	35	[%]
Impact strength (ISO-V):	45 (-196°C)	[J]

Positions: all except PG

Redrying: 300°C/2h

Dimension:

Ø [mm]	Length [mm]	Welding current [A]
2,0	300	40 - 60
2,5	300	60 - 90
3,25	350	80 - 110
4,0	350	100 - 150
5,0	450	150 - 200

Polarity

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