

Standards:

EN ISO 3581-A: E 25 9 3 N LR 32
 EN 1600: EZ 25 9 3 Cu N LR 23
 Mat.-No.: ~1.4501

capilla® 4460 Cu

Recovery:

130%

Product description:

Rutile-basic coated stick electrode for welding of super duplex steels. Good resistance against inter-crystalline corrosion, stress corrosion cracking and pitting corrosion;

Suitable for applications requiring a combination of very good corrosion resistance and excellent mechanical properties;

Service temperature $\leq 250^{\circ}\text{C}$.

Applications:

Overlay and fusion welding of super duplex stainless steel;

Base metals:

GX 3 CrNiMoCuN 26-6-3 (1.4515),
 GX 3 CrNiMoCuN 26.6-3-3 (1.4517),
 25%-Cr super duplex steels (SAF 25/07; Zeron 100)

Typical weld metal composition:

[wt. - %]

	C	Si	Cr	Ni	Mo	Mn	W	Cu	N	Fe
Min.			24	8	2,5	1	0,5	0,5	0,15	
Max.	0,02	0,8	26	10	3,5	1,2	0,7	0,8	0,18	Bal.

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Tensile strength R_m :	730	[MPa]
Yield strength $R_{p0,2}$:	550	[MPa]
Yield strength $R_{p1,0}$:	-	[MPa]
Elongation (L=5d):	23	[%]
Impact strength (ISO-V):	50	[J]

Positions:

all except PG

Redrying:

300°C/2h

Dimension:

$\varnothing$ [mm]	Length [mm]	Welding current [A]	Polarity
2,5	300	60 – 90	= (+)~
3,25	350	80 – 120	
4,0	350	110 – 170	
5,0	450	150 – 200	

also available:

find in table of content

Capilla 4460 Cu MAG

Capilla 4460 Cu WIG