

Standards:

EN ISO 3581-A

EN 1600

Mat.-No.:

E 25 9 4 N LB 12

E 25 9 3 N LB 12

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capilla® 4460 CuB**Product description:**

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: $300^{\circ}\text{C}/2\text{h}$

Dimension:

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

Polarity

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also available:

find in table of content

Capilla 4460 Cu MAG

Capilla 4460 Cu WIG