Standards:

EN ISO 3581-A: E 25 9 3 Cu N B 32
EN 1600: E 25 6 3 Cu LB 23
Mat.-No.: 1.4507

capilla® 4507

Product description:

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

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

Service temperature ≤ 250°C

Applications:

Overlay and fusion welding of super duplex stainless steels.

Base metals:

GX 3 CrNiMoCuN 26-6-3 (1.4515),
GX 3 CrNiMoCuN 26.6-3-3 (1.4517)

Typical weld metal composition:

[wt. - %]

	C	Si	Cr	Ni	Mo	Mn	N	Cu	Fe
Min.			**24,5**	**9**	**3**	**0,8**	**0,15**	**1,5**	
Max.	**0,03**	**1**	**26**	**10**	**4**	**1,2**	**0,2**	**2,5**	**Bal.**

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Tensile strength R_m:	720	[MPa]
Yield strength $R_{p0,2}$:	530	[MPa]
Yield strength $R_{p1,0}$:	-	[MPa]
Elongation (L=5d):	15	[%]
Impact strength (ISO-V):	50	[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
=(+)~

also available:
find in table of content

Capilla G 4507 RM (tubular wire)