

Standards:		capilla® 4830
EN ISO 3581-A:	EZ 25 24 Nb B 32	
EN 1600:	EZ 25 24 Nb B 32	
Mat.-No.:	1.4830	
Recovery:	120%	

Product description:	Applications:
Basic coated high recovery stick electrode; The deposited weld metal has a fully austenitic structure with carbide precipitations.	Fusion welding and cladding of heat resistant fully austenitic steels and similar alloyed steel casts, e.g.
Scaling resistant up to 1000°C	Material No.: 1.4855, 1.4845.

Typical weld metal composition:

[wt. - %]

	C	Cr	Ni	Nb	Fe
Min.		24	23	0,9	
Max.	0,25	26	25	1,2	Bal.

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Tensile strength R_m :	600	[MPa]
Yield strength $R_{p0,2}$:	400	[MPa]
Yield strength $R_{p1,0}$:	450	[MPa]
Elongation (L=5d):	10	[%]

Positions: all except PE and PG

Redrying: 320°C/2h

Dimension:	Ø [mm]	Length [mm]	Welding current [A]	Polarity
	2,5	300	60 – 90	=(+)~
	3,25	350	80 – 110	
	4,0	350	100 – 150	