

Standards:

EN ISO 3581-A: EZ 21 32 Nb B 32
 EN 1600: EZ 21 32 Nb B 32
 Mat.-No.: ~1.4850

capilla® 4850**Recovery:****130%****Product description:**

Basic coated high recovery stick electrode;
 The deposited weld metal has a fully austenitic
 structure with carbide precipitations.

Scaling resistant up to 1050°C

Applications:

Joint and overlay weldings at heat resistant steels
 and sorts of steel cast which have similar alloying
 composition e.g.

Material No.: 1.4876, 1.4861, 1.4859.

Typical weld metal composition:

[wt. - %]

	C	Cr	Ni	Nb	Fe
Min.	0,12	21	32	0,9	
Max.	0,18	23	35	1,2	Bal.

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Tensile strength R_m :	600	[MPa]
Yield strength $R_{p0,2}$:	380	[MPa]
Yield strength $R_{p1,0}$:	400	[MPa]
Elongation (L=5d):	25	[%]
Impact strength (ISO-V):	50	[J]

Positions: all except PE and PG

Redrying: 320°C/2h

Dimension:

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

also available:

find in table of content

Capilla 4850 MAG

Capilla 4850 WIG