

Standards:		capilla® 4853
EN ISO 3581-A:	EZ 25 35 Nb B 32	
EN 1600:	EZ 25 35 Nb B 32	
EN 14700:	~E Ni 1	
Mat.-No.:	~1.4853	
Recovery:	130%	

Product description:	Applications:
Basic coated high-recovery stick electrode suitable for welding of high heat resistant steel casts.	Fusion welding and cladding of similar alloyed heat resistant steels and steel casts e.g.
The weld metal is scaling resistant at service temperatures up to 1050°C.	Material No.: 1.4852

Typical weld metal composition:

[wt. - %]

	C	Cr	Ni	Nb	Mn	Fe
Min.	0,3	25	34	1,2	0,9	
Max.	0,5	27	36	1,5	1,1	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):	8	[%]

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	

also available:
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Capilla 4853 MAG
Capilla 4853 WIG