

Standards:

EN ISO 3581-A: EZ 18 36 Nb B 32
 EN 1600: EZ 18 36 Nb B 32
 EN 14700: ~E Ni 1
 AWS A 5.4: ~ E330-15
 Mat.-No.: ~ 1.4863

Recovery: 130%

capilla® 4863

Product description:

Basic coated high-recovery electrode suitable for welding of high heat resistant steels and steel casts. Scaling resistant at service temperatures up to 950°C. High resistance to carburizing atmosphere.

Applications:

Fusion welding and cladding of similar alloyed heat resistant steels and steel casts e.g.

Material No.: 1.4849, 1.4864, 1.4865.

Typical weld metal composition:

[wt. - %]

	C	Cr	Ni	Nb	Fe
Min.	0,19	17	34	1,2	
Max.	0,25	19	36	1,5	Bal.

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Tensile strength R_m :	550	[MPa]
Yield strength $R_{p0,2}$:	320	[MPa]
Yield strength $R_{p1,0}$:	340	[MPa]
Elongation (L=5d):	15	[%]
Impact strength (ISO-V):	40	[J]

Positions: all except PE and PG

Redrying: 320°C/2h

Dimension:

Ø [mm]	Length [mm]	Welding current [A]
2,5	300	60 – 90
3,25	350	80 – 110
4,0	350	100 – 150

Polarity
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