

Standards: EN ISO 14172: ~E Ni 6702 (NiCr28Fe6W) Mat.-No.: ~2.4879 Recovery: 130%	capilla® 4879
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Product description: Basic coated high recovery stick electrode suitable for welding of heat resistant Ni-base alloys and very high alloyed NiCr(W)-steel casts. Scaling resistant at service temperatures up to 1150°C.	Applications: Fusion welding and cladding of similar alloyed heat resistant alloys e.g. Material No.: 2.4879.
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Typical weld metal composition:

[wt. - %]

	C	Cr	Ni	W	Fe
Min.	0,4	27	48	4	
Max.	0,6	30	52	5	Bal.

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Tensile strength R _m :	650	[MPa]
Yield strength R _{p0,2} :	450	[MPa]
Yield strength R _{p1,0} :	500	[MPa]
Elongation (L=5d):	5	[%]
Impact strength (ISO-V):	-	[J]

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	