

Standards: Special electrode (no standard) Mat.-No.: 2.4813		capilla® 50/50 Nb
Recovery: 200%		

Product description: Rutile-basic coated special electrode suitable for construction welding of furnaces, burners and chimneys, especially if high mechanical stresses in combination with hot gas corrosion caused by sulphurous and vanadium containing media have to be expected. High preheating (600 °C) before the welding is recommended.	Applications: Scaling resistant in atmospheric gases and flue gases up to 1150°C . Base metals: IN 560, IN 657, IN 671.
---	---

Typical weld metal composition:

[wt. - %]

	C	Cr	Nb	Fe	Ni
Min.		48	1,5		
Max.	0,1	49	1,8	0,8	Bal.

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Tensile strength R _m :	900	[MPa]
Yield strength R _{p0,2} :	690	[MPa]
Yield strength R _{p1,0} :	450	[MPa]
Elongation (L=5d):	3	[%]

Positions: PA, PB, PC

Redrying: 320°C/2h

Dimension:	Ø [mm]	Length [mm]	Welding current [A]	Polarity = (+) ~
	2,5	350	60 – 90	
	3,25	350	80 – 110	
	4,0	450	100 – 150	