

Standards:

EN 14700: E Ni2-200-ckptz
 EN ISO 14172: E Ni6617(NiCr22Co12Mo)
 AWS A5.11: E NiCrCoMo 1
 Mat.-No.: 2.4628

capilla® 533**Recovery: 170%****Product description:**

Stick electrode for cladding and fusion welding of Ni-Cr-Co-Mo-alloys and for fusion welding of these materials with steels.

Fusion welding of dissimilar heat resistant Ni-base-alloys.

The weld metal is creep-resistant and scaling resistant at service temperatures up to 1100°C.

Applications:

Chemical equipment construction, fume gas desulphurisation plants, gas turbines, booster, furnaces.

Cladding of thermally highly loaded hot forming tools.

Base materials:

2.4851 (Alloy 617), 1.4958 (Alloy 800),
 2.4851 (Alloy 601), 1.4862.

Typical weld metal composition:

[wt. - %]

	C	Cr	Co	Mo	Mn	Fe	Ti	Al	Ni
Min.		20	10	8					
Max.	0,05	22	14	10	0,5	1	1	0,3	Bal.

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Tensile strength R _m :	700	[MPa]
Yield strength R _{p0,2} :	400	[MPa]
Yield strength R _{p1,0} :	-	[MPa]
Elongation (L=5d):	30	[%]
Impact strength:	60	[J]

Positions: PA, PB, (PC)

Redrying: 320°C/2h

Dimension:

Ø [mm]	Length [mm]	Welding current [A]
2,5	350	60 – 90
3,25	350	80 – 110
4,0	450	100 – 150
5,0	450	150 – 200

Polarity
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also available:
 find in table of content

Capilla 533 MAG
 Capilla 533 WIG