

Standards:		capilla® 6000 B
EN ISO 14172:	~E Ni 6082 (NiCr20Mn3Nb)	
EN 14700:	E Ni 2	
AWS A 5.11:	~E NiCrFe-3	
Mat.-No.:	~2.4648	
Recovery:	150%	

Product description:	Applications:
Basic coated stick electrode for fusion welding and cladding of nickel alloys and cryogenic nickel steels. In case of dissimilar welding of nickel base materials to carbon steels even at high temperatures no carbon diffusion from the ferritic base material into the fully austenitic weld metal occurs. Good resistance to thermal shocks.	Especially suitable for dissimilar joints at service temperatures in the range of -196°C to + 650°C. Service temperature limitations: Scaling resistant up to 1000 °C; in sulphurous atmosphere max. 500 °C; fully loaded welds max. 800 °C. Material Nos.: 1.4876, 2.4870, 2.4867, 2.4816, 1.5662, 1.4429, 1.4539, 1.4922 and joints of these materials with low alloyed steels.

Typical weld metal composition:

[wt. - %]

	C	Cr	Mn	Nb	Fe	Ni
Min.	0,03	18	4	2	3	
Max.	0,06	21	6	2,8	5	Bal.

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Tensile strength R _m :	620	[MPa]
Yield strength R _{p0,2} :	380	[MPa]
Yield strength R _{p1,0} :	420	[MPa]
Elongation (L=5d):	35	[%]
Impact strength (ISO-V):	90	[J]
	70	[J] -196°C

Positions: all except PD, PE and PG

Redrying: 320°C/2h

Dimension:	Ø [mm]	Length [mm]	Welding current [A]	Polarity
	2,0	300	40 – 60	=(+)~
	2,5	350	60 – 90	
	3,25	350	80 – 120	
	4,0	350	110 – 160	
	5,0	350	150 – 190	

also available:
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Capilla 6000
Capilla 6000 DL

Capilla 6000 MAG
Capilla 6000 WIG