

Standards:

EN ISO 14172: E Ni 6082 (NiCr20Mn3Nb)
 EN 14700: E Ni 2-200-ckptz
 AWS A5.11: ~E Ni Cr Fe-3
 Mat.-No.: 2.4648
Recovery: **150%**

capilla® 6000**Product description:**

Basic coated high-recovery stick electrode for fusion and overlay welding. The weld metal is very ductile. Welding of nickel base alloys and tough at subzero nickel steels (cryogenic applications). Even at high temperatures, no carbon diffusion from the ferritic base metal into the fully austenitic weld metal occurs. Good resistance to thermal shocks.

Applications:

Especially suitable for dissimilar joints at working temperatures in the range of -196°C to $+650^{\circ}\text{C}$.

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 to mild steels.

Typical weld metal composition:

[wt. - %]

	C	Cr	Mn	Nb	Fe	Ni
Min.		18	4	2	3	
Max.	0,15	21	6	2,8	5	Bal.

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

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

Positions: all except PD, PE and PG

Redrying: $320^{\circ}\text{C}/2\text{h}$

Dimension:

Ø [mm]	Length [mm]	Welding current [A]	Polarity
2,0	350	40 – 60	= (+) ~
2,5	350	60 – 90	
3,25	350	80 – 110	
4,0	450	100 – 150	
5,0	450	150 – 200	

also available:
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Capilla 6000 B
 Capilla 6000 DL

Capilla 6000 MIG
 Capilla 6000 WIG