

CARBO S- 2.4831

CARBO T- 2.4831

International standards

	S = solid wire	T = bare rod
Mat. No.	2.4831	
DIN 1736	SG-NiCr 21 Mo 9 Nb	SG-NiCr 21 Mo 9 Nb
AWS A 5.14	ERNiCrMo-3	ERNiCrMo-3

Approvals

TÜV

TÜV

Application notes

Nickel base wire electrode for welding nickel alloys and could tough nickel steels, joining dissimilar steels and welding joints between austenitic and ferritic metals.

Operating temperature

-196° C bis +550° C

Base materials

1.4558 X2NiCrAlTi32-20	2.4851 NiCr23Fe
2.4631 NiCr20TiAl	2.4856 NiCr22Mo9Nb
2.4605 NiCr23Mo16Al	2.4858 NiCr21Mo
2.4618 NiCr22Mo6Cu	1.4951 X6CrNi25-20
2.4619 NiCr22Mo7Cu	1.5662 X8Ni9
2.4630 NiCr20Ti	1.5680 X12Ni5
2.4641 NiCr21Mo6Cu	1.5681 GX10Ni5
2.4660 NiCr20CuMo	1.6907 X3CrNi18-10
2.4951 NiCr20Ti	1.6967 X3CrNiMoN18-4
2.4816 NiCr15Fe	1.4876 X10NiCrAlTi32-20
2.4817 LC-NiCu15Fe	1.4959 X8NiCrAlTi32-21
	Alloy 800, 800HT

Joints of: Ni-Base + Austenit / Ni-Basis + Ferrit / Austenit + Ferrit
up to 550° C

Mechanical properties of all-weld-metal

(typical values)

Tensile strength R_m N/mm ²	Yielding strength $R_{p0,2}$ N/mm ²	Elongation A_5 %	Impact strength ISO – V J at -40° C
760	420	30	60

Weld metal analysis

(typical, wt %)

C	Si	Mn	Cr	Mo	Ni	Nb	Fe
0,03	0,25	0,20	22,0	9,0	Base	3,6	< 1,5

Gas types EN 439

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Current

Diameter mm
Welding amps (A) min.
(A) max.

	= +				= -				
Diameter mm	0,8	1,0	1,2	1,6	1,6	2,0	2,4	3,2	4,0
Welding amps (A) min.	80	120	180	250					
Welding amps (A) max.	130	190	250	320					

coils, weight

Rev. 001/13

B300 15 kg.

10 kg.