

Standards

Material No.	2.4806 / 2.4648
DIN 1736	EL-NiCr 19 Nb
AWS A5.11	ENiCrFe-2 / mod.

Characteristics

Nickel base tubular wire, suitable for joining and cladding low alloyed and alloyed steels, welding iron- and nickel base alloys and for dissimilar joints.

The austenitic deposit is insensitive to hot-cracking and free of embrittlement at high as well as at low temperatures, non-scaling up to 1000° C, and cold tough down to -196° C.

No diffusion of carbon into the weld metal at high temperatures.

Used for service-temperatures of more than 300° C in Chemical Industry, Petrochemical Industry, glassworks, civil engineering, repairing and maintenance workshops.

Operating temperature - 196° C up to 550° C

Mechanical properties of all-weld metal (typical values)

Tensile strength R _m N/mm ²	Yield strength R _{p0,2} N/mm ²	Elongation A ₅ %	Impact strength ISO-V J 20°C
650	380	>35	>32

Weld metal analysis (typical, wt. %)

C	Mn	Mo	Cr	Ni	Fe	Nb
< 0,04	3,5	<1	19	Basis	< 4	2

Gas types EN 439

I1, Argon

Current

= +

Current intensity

DIA (mm)	DIA (inch)	Volt	Amps	Delivering form
1,2	3/64	19 - 22	120 - 220	G
1,6	1/16	20 - 26	160 - 260	G
2,0	5/64	22 - 27	220 - 280	G S
2,4	3/32	24 - 28	260 - 340	G S
2,8	7/64	25 - 29	300 - 400	S
3,2	1 / 8	26 - 30	320 - 460	S

Delivering form

O = Flux cored wire self shielding

G = Flux cored wire for shielded arc welding

S = Flux cored wire for submerged arc welding

Coils, weight

B/BS 300 = 15 kg

B 450 = 30 kg

pay off pack = 150 / 300 kg

Rev. 000

Statements on composition and application are just for the applier's information. Statements on mechanical properties always refer to the all-weld-metal according to valid standards. Carbo-Weld may change the characteristics of its products without notice. We recommend the applier to check our products for their special application autonomously.