

# CARBO S-2.4806

# CARBO T-2.4806

## International standards

Mat. Nr.	S = solid wire	T = bare rod
	DIN 1736	SG-NiCr 20 Nb
AWS A 5.7	ERNiCr-3	ERNiCr-3

## Approvals

TÜV

## Application notes

Solid NiCr wire electrode suitable for welding nickel alloys, (see base materials) and joining austenitic to ferritic steels subjected to working temperatures exceeding 300°C and joining dissimilar materials .

## Operating temperature

-196° C bis +550° C

-196° C bis +550° C

## Base materials

2.4630 NiCr20Ti	2.4867 NiCr60 15	1.5680 12Ni19
2.4631 NiCr21TiAl	2.4869 NiCr80 20	1.6900 X12CrNi18 9
2.4669 NiCr15Fe7TiAl	2.4870 NiCr 10	1.6901 GX8CrNi18 10
2.4816 NiCr15Fe	2.4951 NiCr20Ti	1.6903 X10CrNiTi18 10
2.4817 LC-NiCr15Fe	1.5637 12 Ni 14	1.6906 X5CrNi18 10
2.4851 NiCr23Fe	1.5662 X8Ni9	

Joints of

Ni-Base with Austenit / Ni-Basis with Ferrit / Austenit with Ferrit up to 550° C

## Mechanical properties of all-weld-metal

(typical values)

Tensile strength R <sub>m</sub> N/mm <sup>2</sup>	Yielding strength R <sub>p0,2</sub> N/mm <sup>2</sup>	Elongation A <sub>5</sub> %	Impact strength ISO – V J at 20° C
620	380	35	90

## Weld metal analysis

(typical, wt %)

C	Si	Mn	Cr	Ni	Nb	Fe
0,02	0,2	2,8	19,5	> 67	2,5	< 2,0

## Gas types EN 439

S = solid wire

I1

T = bare rod

I1

## Current

		= +				= -				
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					
	(A) max.	130	190	250	320					

coils, weight

Rev. 001/13

B300 15 kg.

10 kg.