

CARBOLOY 2.4879

International standards	Material No.	2.4879
	DIN 1736	EL-NiCr28W (mod.)

Approvals ---

Typical applications and characteristics Resistant to scaling up to 1150°C (2102°F).
For surfacing and joining of matching/similar cast grades.

Structure Austenite

Operating temperature Rt. up to +1150° C

Base materials Thoroughly clean the surface of the work-piece make sure it is exempt from grease (previous grinding). When welding on cast iron, heat input should as low as possible max. +150°C.

Welding instructions For limiting the heat-input low amperage and small gauge electrodes should be preferred.

Mechanical properties of all-weld metal	Tensile strength	Yield strength	Elongation
	R_m N/mm²	R_{p0,2} N/mm²	A₅ %
(typical values)	>650	>480	> 5

Weld metal analysis	C	Si	Mn	Cr	Ni	W	Fe
(typical, wt. %)	0,45	1,1	1,2	30	49	4,5	rest

Current = +

Welding positions PA, PB, PC, PF

Rebaking 2 - 3 h, 250° C +/- 10° C (if required)

Dia./Length	Amperage (A)	kg / packet	kg / carton
2,5 x 300	70 - 90	4,0	16,0
3,2 x 350	90 - 110	5,0	20,0
4,0 x 350	100 - 140	5,0	20,0

RRev. 000