

# CARBO S- 2.4886

# CARBO T- 2.4886

## International standards

	S = solid wire	T = bare rod
Werkstoff Nr.	2.4886	
DIN 1736	SG-NiMo16Cr16W	SG-NiMo16Cr16W
AWS A 5.14	ER NiCrMo-4	ER NiCrMo-4

## Approvals

### Application notes

High alloyed nickel based wire electrode for welding NiMoCr-alloys such as alloy C 276.  
The resulting deposit is resistant to oxidation and reduction corrosion. Overlays are extraordinarily tough and harden with impact stress and high temperatures to about 400 HB without deforming the deposit. When welding thicker overlays, the lower layers should be welded with Carbo T/S-1.4337.  
CARBO T/S 2.4886 is typically hard faced on: molds, hot-forging dies, hammer saddles, ball mandrels, etc.

### Operating temperature

-196° C up to + 400° C

### Base materials

Main applications: Surfacing of hot working tools as hot forging dies, hot shear blades, punches, swages, dies, press tools, milling rolls and valves, etc.

### Mechanical properties of all-weld metal

( typical values)

Tensile strength $R_m$ N/mm <sup>2</sup>	Yield strength $R_{p0,2}$ N/mm <sup>2</sup>	Elongation $A_5$ %	Hardness (HB) as welded / work-hardened	
780	500	25	ca. 230	ca. 400

### Weld metal analysis

(typical, wt. %)

C	Cr	Mo	W	Fe	Ni
0,02	15	16	4,0	5	Bal.

### Gas types EN 439

S = solid wire

I1

T = bare rod

I1

### Current

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

= +				= -				
0,8	1,0	1,2	1,6	1,6	2,0	2,4	3,2	4,0
80	120	180	250					
130	190	250	320					

### coils, weight

Rev. 001/13

B300 15 kg.

10 kg.