

CARBOLLOY B

International standards	Material No.	2.4802
	AWS A5.11	EL- NiMo 1
	DIN 1736	EL – NiMo 28

Approvals ---

Typical applications and characteristics CARBOLLOY B is an AC-weldable electrode with a recovery of 160% for joining and cladding of equal and similar nickel-alloys as for example NiMo 30 (HASTELLOY®-B); it is also suitable for joining such nickel-steel to steel. Furthermore it can be applied for joining austenitic CrNi-steel to equal alloys.
CARBOLLOY B is specifically suitable on base materials subject to chemically reducing attack and is widely resistant against muriatic acid and proves excellent corrosion resistance to wet hydrogen-chloride-gases, sulfuric- and phosphoric-acid and alkaline liquids

Mechanical properties of all-weld metal	Tensile strength R_m N/mm ²	Yield strength $R_{p0,2}$ N/mm ²	Elongation A_5 %	Hardness HB
	(typical values)	680	440	15

Weld metal analysis (typical, wt. %)	C	Mn	Mo	Cr	Ni	Fe
	0,06	0,4	26-30	< 1	Bal.	5

Current = + / ~ , 50 V

Welding positions PA, PB, PC, PD, PE, PF

Rebaking 1 h, 300 °C + / - 10 °C (if required)

Dia./Length	Amperage (A)	Pcs./ packet	Pcs./ carton	kg / 1000	kg / packet	kg / carton
2,5 x 350	55 - 90				5,0	20,0
3,2 x 350	75 - 130				5,0	20,0
4,0 x 350	115 - 190				5,0	20,0