

# CARBO S- 2.4155

# CARBO T- 2.4155

## International standards

	S = solid wire	T = bare rod
Mat. No.	2.4155	
DIN 1736	SG-NiTi 4	SG-NiTi 4
AWS A 5.14	ER Ni-1	ER Ni-1

## Approvals

### Application notes

Solid wire electrode suitable for welding pure nickel and nickel alloys as well as joints between these materials and steel, cast steel, copper claddings and buffer layers

**Operating temperature** -196°C up to +450° C

### Base materials

2.4056 Nickel 200	2.4062 Nickel 201	2.4066 Nickel 99
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### Mechanical properties of all-weld-metal

(typical values)

Tensile strength $R_m$ N/mm <sup>2</sup>	Yielding strength $R_{p0,2}$ N/mm <sup>2</sup>	Elongation $A_5$ %	Impact strength ISO – V J at 20° C
450	300	25	150

### Weld metal analysis

(typical, wt %)

C	Mn	Si	Ti	Ni
0,02	0,4	0,4	3,0	Base

### 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.