

# CARBO 2.4156 B

<b>International standards</b>	Material No.	2.4156
	DIN 1736	EL-NiTi 3
	AWS A5.11	ENi-1

**Approvals** ---

**Typical applications and characteristics**

Basic coated electrode with a nickel deposit containing 1-2% Titan, designated for butt welding and surfacing of nickel-copper, copper-nickel and copper-nickel plated steels. Also recommended for dissimilar joining like: steel/ nickel-copper or steel/copper/copper-nickel. Excellent resistance to stress corrosion in chloride-containing environments. Main applications: construction of equipment for chemical and petrochemical industry, food stuff industry, naval constructions and installations for sea water desalination.

<b>Base materials</b>	2.4060	Ni99,6	2.4109	NiMn1,5	USN N02200
	2.4061	LC-Ni99,6	2.4110	NiMn2	N02201
	2.4062	Ni99,4Fe	2.4116	NiMn5	N02205
	2.4066	Ni99,2	2.4122	NiMn3Al	
	2.4068	LC-99	2.4128	NiAl4Ti	Alloy 200
	2.4106	NiMn1	2.4170	G-Ni95	201
	2.4108	NiMn1C	2.4175	G-Ni93C	205

<b>Mechanical properties of all-weld metal</b>	<b>Tensile strength</b> R <sub>m</sub> N/mm <sup>2</sup>	<b>Yield strength</b> R <sub>p0,2</sub> N/mm <sup>2</sup>	<b>Elongation</b> A <sub>5</sub> %	<b>Impact strength</b> ISO – V J at -196 ° C
	( typical values)	470	310	>30 120

<b>Weld metal analysis</b> (typical, wt. %)	<b>C</b>	<b>Mn</b>	<b>Si</b>	<b>Ti</b>	<b>Ni</b>	<b>Fe</b>	<b>Al</b>
	< 0,02	0,4	1	2,0	Bal.	0,3	0,2

**Current** = +

**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 300	70 - 90	244	976	20,5	5,0	20,0
3,2 x 350	90 - 120	148	592	33,8	5,0	20,0
4,0 x 350	110 - 160	98	390	51,2	5,0	20,0