

<b>International standards</b>	Material No.	1.4948
	EN ISO 3581-A	E 19 9 B 22
	AWS A 5.4	E308H-15

**Approvals** --

**Typical applications and characteristics** CARBO 4948 B is a basic-coated electrode with an alloyed core, suitable for fabrication of austenitic CrNi steels and steel castings. The weld deposit shows excellent creep rupture characteristics. The alloy is also suitable for welding austenitic CrNi steels with carbon contents higher than 0,4 % as well as for ACI conform castings. The alloy is high temperature resistant up to 700 °C and scale resistant up to 800°C.

**Operating temperature** From room temperature up to + 700° C

**Structure** Austenite with 5% ferrite

<b>Base materials</b>	1.4301 X5CrNi18-10	1.4878 X 12CrNiTi19-9
	1.4541 X6CrNiTi18-10	1.4948 X6CrNi18-11
	1.4550 X6CrNiTi18-10	1.4949 X5CrNi18-11

ACI Base Materials:  
CF 3 (CPF 3) / CF 8 (CPF 8) / CF 8 C (CPF 8 C)

<b>Mechanical properties of all-weld metal ( typical values )</b>	<b>Tensile strength R<sub>m</sub> N/mm<sup>2</sup></b>	<b>Yield strength R<sub>p0,2</sub> N/mm<sup>2</sup></b>	<b>Elongation A<sub>5</sub> %</b>	<b>Impact strength ISO – V J at room temperature</b>
	560	350	36	70

<b>Weld metal analysis (typical, wt %)</b>	<b>C</b>	<b>Si</b>	<b>Mn</b>	<b>Cr</b>	<b>Ni</b>
	0,05	0,5	1,5	18,5	9,5

**Current** = +

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

**Rebaking** 1 h, 350° C + / - 10° C ( if necessary)

Dia./Length	Amperage (A)	Pcs./packet	Pcs./carton	kg/1000	kg/packet	kg/carton
2,0 x 300	50 - 70	408	1633	9,8	4,0	16,0
2,5 x 300	60 - 90	260	1039	15,4	4,0	16,0
3,2 x 350	80 - 120	165	660	30,3	5,0	20,0
4,0 x 350	110 - 160	109	436	45,9	5,0	20,0
5,0 x 450	150 - 200	65	261	92,1	6,0	24,0

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