

CARBO 4018 B

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|--------------------------------|---------------|---------------|
| International standards | Material No. | 1.4018 |
| | EN ISO 3581-A | E 13 B 22 |
| | AWS A 5.4 | E 410-15 mod. |

Characteristics and typical applications

CARBO 4018 B is a basic coated stick electrode suitable for hard facing and joining of rustproof and corrosion resistant 13 % Cr(Ni)-steels and cast steels. To be used for hard facing on sealing surfaces of water-, steam and gas fittings made of unalloyed or low alloyed steels and cast steels.

Operating temperature Rt. 450°C

Base materials 1. 4008 G – X 22 Cr 14

Instructions for use

Insure a low heat input, as ferritic chrome-steels tend to embrittle by forming coarse-grained structures.

For hard facings on low allowed and more tensile base materials a pre-heating to 100-250° C is only necessary for greater wall thicknesses. This can be followed by annealing.

Mechanical properties of all-weld metal

(typical values)

| Tensile strength R_m N/mm ² | Yield strength $R_{p0,2}$ N/mm ² | Elongation A_5 % | Impact energy ISO – V J at -60° C |
|---|--|-----------------------|---|
| 650 | 450 | 15 | 50 |

Weld metal analysis (typical, wt %)

| C | Si | Mn | Cr | Ni |
|------|-------|-----|----|-----|
| 0,06 | < 0,4 | 0,5 | 13 | 1,3 |

Current = +

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

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

Dimensions Current intensity No. of pieces/net weights (typical values)

| Dia./Length | Amperage (A) | Pcs./packet | Pcs./carton | Kg/1000 pcs. | Kg/packet | Kg/carton |
|-------------|--------------|-------------|-------------|--------------|-----------|-----------|
| 2,5 x 300 | 40 - 60 | 260 | 1035 | 15,4 | 4,0 | 16,0 |
| 3,2 x 350 | 70 - 110 | 135 | 552 | 37,2 | 5,0 | 20,0 |
| 4,0 x 350 | 90 - 140 | 68 | 364 | 74,1 | 5,0 | 20,0 |
| 5,0 x 450 | 130 - 190 | 54 | 218 | 110,2 | 6,0 | 24,0 |

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