

# CARBO 4820 AC

<b>International standards</b>	Material No.	1.4820
	EN ISO 3581-A	E 25 4 R 12
	DIN 8556	E 25 4 MP R 23

**Approvals** --

**Typical applications and characteristics**

CARBO 4820 AC is an AC-weldable fully core-wire alloyed electrode for fabrication-welding on equal or similar, corrosion and heat-resistant steels and steel-castings.

The weld-deposit is on equal base-material scale-resistant and, by reason of its low nickel-content, resistant against attack of sulphurous gases at higher temperatures up to 1150°C. When welding CARBO 4820 AC low heat-input should be guaranteed as alloys of such chemistry are sensitive to embrittlement at 600-800°C.

The interlayer-temperature must not exceed 300°C.

**Operating temperature** From room temperature up to + 1150° C

<b>Base materials</b>	1.4340	GX40CrNi27-4	1.4745	GX40CrSi23
	1.4710	GX30CrSi6	1.4746	X8CrTi25
	1.4711	X10CrSi6	1.4762	X10CrAl24
	1.4722	X10CrSi13	1.4776	GX40 CrSi29
	1.4723	X10 CrAl13	1.4821	X20CrNiSi25-4
	1.4740	GX40CrSi17	1.4822	GX40CrNi24-5
	1.4741	X2CrAlTi18-2	1.4823	GX40CrNiSi27-4
	1.4742	X10CrAl18		

**Mechanical properties of all-weld metal ( typical values )**

Tensile strength $R_m$ N/mm <sup>2</sup>	Yield strength $R_{p0,2}$ N/mm <sup>2</sup>	Elongation $A_5$ %	hardness HB
700	500	20	Ca. 180

**Weld metal analysis (typical, wt %)**

C	Si	Mn	Cr	Ni
0,06	1,0	0,7	25	4,7

**Current** = + / ~ / 50 V

**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
2,5 x 300	60 - 80	222	889	18,0	4,0	16,0
3,2 x 350	80 - 100	145	580	33,7	5,0	20,0
4,0 x 350	120 - 150	95	381	52,8	5,0	20,0

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