

CARBO 4820 MPR

International Standards

Material No.	1.4820
EN ISO 3581-A	E 25 4 R 52

Approvals

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Typical applications and characteristics

CARBO 4820 MPR is an AC-weldable electrode with a recovery of 140% 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°C - 800°C. The interlayer-temperature must not exceed 300°C.

Operating temperature

From room temperature up to + 1150° C

Base material

1.4340 GX40CrNi27-4	1.4745 GX40CrSi23
1.4710 GX30CrSi 6	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 ²	Yield strenght R _{p0,2} N/mm ²	Elongation A5 %	hardness HB
700	500	20	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

Rebaking

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

Dia./Length	Amperage (A)	Pcs./packet	Pcs./carton	kg /1000 pcs.	kg / packet	kg / carton
2,5 x 350	70 - 90	178	712	28,3	5,0	20,0
3,2 x 350	80 - 120	105	421	47,5	5,0	20,0
4,0 x 450	120 - 170	65	259	92,6	6,0	24,0
5,0 x 450	170 - 240	41	166	144,7	6,0	24,0