

CARBO S-1.4440 CARBO T-1.4440

International standards

	S = solid wire $T = bare rod$				
Mat. No.	1.4440				
EN 12072	G 18 16 5 NL	W 18 16 5 NL			
AWS A 5.9	~ER317L	~ER317L			

Application notes

Solid wire electrode for joining corrosion-proof CrNiMo steels of low carbon content as well as stabilised and non-stabilised steels of identical or similar characteristics which are resistant to chemical agents. Used on a base metal of identical characteristics the weld metal is resistant to wet corrosion up to 350° C.

Scale resistant up to 875° C in an air and oxidising gases atmosphere. No intercrystalline corrosion due to low carbon content.

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The deposit is capable of taking high polish.

Also approved for joining austenitic to ferritic steels (weld thin stringer beads)

Welding wire with higher molybdenum content than for ER 316. The reduced carbon content (maximum 0.03%) offers higher resistance to inter-granular corrosion due to carbide precipitation. This welding wire offers has extreme **corrosion resistance** to sulfuric and sulfurous acids and their salts.

Base materials

1.44291.44461.44321.44481.4434

Mechanical properties of all-weld metal

(typical values)

Tensile strength R _m N/mm²	Yield strength R _{p0,2} N/mm ²	Elongation A₅ %	Impact strength ISO – V J at - 60° C
520	>320	>30	>80

Weld metal analysis (typical, wt. %)

С	Si	Mn	Cr	Ni	Мо	N
≤0,025	0,35	3,5	18,5	17,5	4,5	0,15

	S = solid wire			T = bare rod							
Gas types EN 439		M12									
Current			= +				=-				
Diameter	mm	0,8	1,0	1,2	1,6	1,6	2,0	2,4	3,2	4,0	
Welding amps	(A) min.	80	120	180	250						
	(A) max.	120	180	230	300						
coils, weight		B300 1	5 kg.			10 kg.					

Statements on composition and application are just for the applier's information. Statements on mechanical properties always refer to the all-weld-metal according to valid standards. Carbo-Weld may change the characteristics of its products without notice. We recommend the applier to check our products for their special application autonomously.