

Standards

Material No.	1.4462
AWS	ER 22 09
DIN 8556	SGX2 CrNiMo 22 8 3

Characteristics and typical applications

CARBO UP 4462 and CARBO FLUX E 2 is a wire – powder combination for submerged arc welding suitable for joints and surfacing on matching Duplex steels such as 1.4462

Base materials

1.4417 X2CrNiMoSi19-5
1.4462 X2CrNiMoN22-5-3
1.4463 GX6CrNiMo24-8-2

Recommendations for fabrication

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 strength ISO – V J + 20°C
780	570	32	130

Weld metal analysis (typical, wt %)

C	Si	Mn	Cr	Ni	Mo	N	Fe
0,02	0,5	1,2	22,0	9,0	2,8	0,12	Base

Current

= +

Current intensity

DIA (mm)	Volt	Amps	Delivering form	
3,0	25 - 29	300 - 400		S

Coils, weight

B 450 = 30 kg

Rev. 000