

CARBO S- 4551

CARBO T- 4551

International standards

	S = solid wire	T = bare rod
Werkstoff Nr.	1.4551	
EN 12072	G 19 9 Nb Si	W 19 9 Nb
AWS A 5.9	ER347Si	ER347
DIN 8556	SG X5 CrNiNb 19 9	SG X5 CrNiNb 19 9

Approvals

TÜV, DB, CE

TÜV, DB, CE

Application notes

Stabilised CrNiNb wire/rod electrode for joining corrosion-resistant stabilised and non-stabilised steels of identical or similar characteristics which are resistant to chemical agents. For service temperatures from – 110°C up to 400 °C.
Non scaling up to +800°C.

Operating temperature

-110° C bis +400° C

Base materials

1.4301	1.4306	1.4541	1.4308	1.4310
1.4550	1.4552	1.4319	1.4303	1.4312

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 at 20° C
680	490	32	70

Weld metal analysis

(typical, wt. %)

C	Si	Mn	Cr	Ni	Nb
0,04	0,8	1,3	19,5	9,5	12 x % C

Gas types EN 439

S = solid wire
M11, M12, M13

T = bare rod
I1

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.	130	190	250	320					

coils, weight

Rev. 001/13

B300 15 kg.

10 kg.