

<b>International standards</b>	Material No.	1.4462
	EN ISO 3581-A	E 22 9 3 N L R 12
	AWS A 5.4	E2209-17

**Approvals** TÜV

**Typical applications and characteristics** CARBO 4462 AC is an AC-weldable electrode with an alloyed core, suitable for welding on compound steels of same or similar steels. (DUPLEX SS 2205 (UNS S 32205) 1.4462 )  
The weld deposit is resistant to pitting, stress corrosion cracking and intercrystalline corrosion at temperatures up to 250° C.  
Furthermore, the weld metal alloy is saltwater-proof and performs high tensile strength, as a result of nitrogen being added to the alloy.

**Operating temperature** - 40° C up to + 250° C

<b>Base materials</b>	1.4347	GX8CrNiN26-7	1.4462	X2CrNiMoN22-5-3
	1.4362	X2CrNiN23-4	1.4463	GX6CrNiMo24-8-2
	1.4417	GX2CrNiMoN25-7-3	1.4470	GX2CrNiMoN22-5-3
	1.4426	GX10CrNiMoN15-4-2	1.4575	X1CrNiMoNb28-4-2
	1.4460	X3CrNiMoN27-5-2	1.4582	X4CrNiMoNb25-7

Dissimilar joints of 1.4462 with 1.4583 and  
1.4462 with H I / H II, 17 Mn 4, 15 Mo 3, StE 255 up to StE 355  
P235GH / P256GH, P295GH, 16Mo3, P255N up to P355N

<b>Mechanical properties of all-weld metal</b>  ( typical values )	<b>Tensile strength R<sub>m</sub></b> N/mm <sup>2</sup>	<b>Yield strength R<sub>p0,2</sub></b> N/mm <sup>2</sup>	<b>Elongation A<sub>5</sub></b> %	<b>Impact strength ISO – V J</b> - 40° C
	780	610	26	44

<b>Weld metal analysis</b> (typical, wt %)	<b>C</b>	<b>Si</b>	<b>Mn</b>	<b>Cr</b>	<b>Ni</b>	<b>Mo</b>	<b>N</b>
	< 0,03	0,9	0,7	22,5	9	3,3	0.12

**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
2,0 x 300	30 - 60	345	1379	11,6	4,0	16,0
2,5 x 300	40 - 70	221	884	18,1	4,0	16,0
3,2 x 350	60 - 110	140	559	35,8	5,0	20,0
4,0 x 350	90 - 145	92	369	54,2	5,0	20,0
5,0 x 450	120 - 180	55	221	108,8	6,0	24,0

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