

CARBO 4576 MPR

International Standards	Material No.			1.45	1.4576					
	EN ISO 3581-A			E 19	E 19 12 3 Nb R 53					
	AWS A 5.4			E318	E318-26					
Approvals										
Typical applications and characteristics	CARBO 4576 MPR is a high recovery electrode (160%) for AC-welding, suitable for joining corrosion-proof CrNiMo-steels as well as stabilized and non-stabilized base materials of same or similar characteristics which are resistant to chemical agents. Combined with a base material of same characteristics the weld metal is resistant to wet corrosion up to 400°C. The weld metal alloy is scale-resistant up to 875°C in air and in oxidizing gases atmosphere.									
Operating temperature	- 60°C up to + 400°C									
Base materials	1.4401 X5CrNiMo17-12-21.4571 X6CrNiMoTi17-12-21.4436 X3CrNiMo17-13-31.4579 X6CrNiMoTi17-12-21.4437 GX6CrNiMo18-121.4580 X6CrNiMoNb17-12-21.4408 GX5CrNiMo19-11-21.4583 (G)X10CrNiMoNb18-12							12-2 12-2 -12-2 Ib18-12		
Mechanical properties of all-weld metal	Tensile strength Rm N/mm ²		Yield strenght Rp0,2 N/mm ²		Elongation A5 %		Impact strenght ISO-V at - 60°C			
(typical values	590		400		36			>32		
	•	0:	Min			NI:	Ma	NIL		
(typical wt %)		0.8			or O	11	2.6			
(-)[,/	< 0,07	0,8	0,0		9	11	2,0	<u>20xC/0</u>		
Current	= + / ~ , 50 V									
Welding positions	PA, PB									
Rebaking	1 h, 350°C + / - 10°C (if nacessary)									
Dia./Length Amperage (A)	Pcs./pacl	ket Pcs	./carton	kg /100	00 pcs	. kg / pa	cket	kg / carton		

Dia./Length	Amperage (A)	Pcs./packet	Pcs./carton	kg /1000 pcs.	kg / packet	kg / carton
2,0 x 300	50 - 90	238	952	16,8	4,0	16,0
2,5 x 300	80 - 100	163	611	26,2	4,0	16,0
3,2 x 350	90 - 130	97	388	51,6	5,0	20,0
4,0 x 350	130 - 180	64	256	78,2	5,0	20,0
5,0 x 450	130 - 170	38	152	157,0	6,0	24,0

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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.