

CARBO 4316 MPR

International Standards

Material No.	1.4316
EN ISO 3581-A	E 19 9 L R 53
AWS A 5.4	E308L-26

Approvals

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Typical applications and characteristics

CARBO 4316 MPR is an AC-weldable, rutile coated electrode with a recovery of 160 % suitable for joining corrosion-proof CrNi steels with 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. CARBO 4316 MPR is scale resistant up to 875°C in an air and oxidising gases atmosphere. No intercrystalline corrosion due to low carbon content. The weld metal is capable of taking high polish.

Operating temperature

- 120°C up to + 350°C

Base materials

1.4300 X 12 CrNi 18 8	1.4311 X2CrNi18-10
1.4301 X5CrNi18-10	1.4312 GX10CrNi18-10
1.4303 X4CrNi18-12	1.4541 X6CrNiTi18-10
1.4306 X2CrNi19-11	1.4550 X6CrNiNb18-10
1.4308 GX5CrNi19-10	1.4552 GX5CrNiNb19-11
1.4309 GX2CrNi19-11	

Mechanical properties of all-weld metal (typical values

Tensile strength Rm N/mm ²	Yield strength R _{p0,2} N/mm ²	Elongation A5 %	Impact strength ISO-V at - 120°C
530	320	>35	>32

Weld metal analysis (typical, wt %)

C	Si	Mn	Cr	Ni
≤ 0,04	0,9	0,8	20,0	10,0

Current

= + / ~ , 50 V

Welding positions

PA, PB

Rebaking

1 h, 350° C + / - 10° C (if necessary)

Dia./Length	Amperage (A)	Pcs./packet	Pcs./carton	kg /1000 pcs.	kg / packet	kg / carton
2,0 x 300	40 - 75	238	952	16,8	4,0	16,0
2,5 x 350	50 - 100	163	651	30,7	5,0	20,0
3,2 x 350	80 - 130	96	385	51,9	5,0	20,0
4,0 x 450	110 - 180	59	238	101,0	6,0	24,0
5,0 x 450	170 - 250	38	152	157,8	6,0	24,0