

## CARBO 4410 AC

International Standards	Material No.			~	~1.4410				]		
	EN ISO 3581-A			E	E 25 9 4 N L R 32						
	AWS A 5.4			E	E2594-16						
Approvals											
Typical applications and characteristics	CARBO 4410 AC is an AC-weldable electrode with an alloyed core, suitable for welding on Duplex- and Super-Duplex-steels of same or similar steels. The duplex weld deposit provides exellent resistant to pitting, chloride stress corrosion cracking and intercrystalline corrosion due to the high CrMo(N) content (PReN - Pitting index $\geq$ 40). 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										
Base materials	1.4410 X2 CrNiMoN25-7-4 1.4501 X2 CrNiMoCuWN25-7-4   1.4462 X2 CrNiMoN22-5-3 1.4508 GX2 CrNiMoCuWN25-8-4   1.4468 GX2 CrNiMoN25-6-3 1.4515 GX2 CrNiMoCuN26-6-3   1.4469 GX2 CrNiMoN26-7-4 1.4517 GX2 CrNiMoCuN25-6-3-3   Zeron 100 X2 X2 X2										
Mechanical properties of all-weld metal ( typical values	Tensile strength Rm N/mm	th R <sub>p0,2</sub> N/mm <sup>2</sup>			gation 5 %	Impact strer DVM J at - 4		Impact strenght DVM J at - 46°C			
()	850	70	700		30	>40J		>27J			
Weld metal analysis	С	Si	Mn		Cr	Ni	N	lo	N		
(typical, wt %)	<u>≤</u> 0,03	0,6	0,8		25,5	9,5		,0	0,25		
· · · · · · · · · · · · · · · · · · ·	_ 0,00	0,0	0,0		20,0	0,0		,0	0,20		
Current	= + / ~ , 42	2 V									
Welding positions	ons PA, PB, PC, PD, PE, PF										
Rebaking	2 h, 250° C + / - 10° C (if nacessary)										
Dia /Length Amperage (A)	Pcs /pac	ot Dos	carton	ka	/1000 m	ka / na	ockot	ka	carton		

Dia./Length	Amperage (A)	Pcs./packet	Pcs./carton	kg /1000 pcs.	kg / packet	kg / carton
2,5 x 300	50 - 80	221	884	18,1	4,0	16,0
3,2 x 350	70 - 110	140	559	35,8	5,0	20,0
4,0 x 350	90 - 140	92	369	54,2	5,0	20,0

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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.