

CARBO 4551 AC

International standards	Material No.		1.4551							
	EN ISO 3581-A		E 19 9 Nb	19 9 Nb R 12						
	AWS A 5.4		E347-17							
Approvals	TÜV, DB, CE									
Characteristics and typical applications	CARBO 4551 AC is an AC-weldable, rutile coated electrode with an alloyed core, suitable for joining corrosion-proof stabilized or unstabilized CrNi 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 400° C. The deposit is scale resistant up to 800°C in an air and oxidising gases atmosphere.									
Operating temperature	-60° C up to +40	0° C								
Base materials	1.4300X 12 CrNi 18 81.4541X6CrNiTi18-101.4301X5CrNi18-101.4550X6CrNiTi18-10.4308GX5CrNi19-101.4552GX5CrNiNb19-11.4312GX10CrNi18-101.4552GX5CrNiNb19-11									
Mechanical properties of all-weld metal	Tensile strength R _m N/mm²	Yield R _{p0,2}	strength N/mm²	n Elongation A₅ %		Impact strength ISO–V J at - 120° C				
(typical values)	600		400		40	53				
Weld metal analysis	C Si	Mn 0.7	Cr	Ni	Nb	0/				
(typical, wt 70)	0,05 0,9	0,7	19	10	2010	70				
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 pcs.	kg/packet	kg/carton
2,0 x 300	25 - 55	345	1379	11,6	4,0	16,0
2,5 x 300	40 - 80	221	884	18,1	4,0	16,0
3,2 x 350	65 - 110	140	559	35,8	5,0	20,0
4,0 x 350	100 - 140	92	369	54,2	5,0	20,0
5,0 x 450	120 - 170	55	221	108,8	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.