

<b>International standards</b>	Material No.	1.4576
	EN ISO 3581-A	E 19 12 3 Nb B 22
	AWS A 5.4	E318-15

**Approvals** ---

**Typical applications and characteristics** CARBO 4576 B is a basic-coated electrode with an alloyed core, 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

<b>Base materials</b>	1.4401 X5CrNiMo17-12-2	1.4571 X6CrNiMoTi17-12-2
	1.4436 X3CrNiMo17-13-3	1.4579 X6CrNiMoTi17-12-2
	1.4437 GX6CrNiMo18-12	1.4580 X6CrNiMoNb17-12-2
	1.4408 GX5CrNiMo19-11-2	1.4583 (G)X10CrNiMoNb18-12

<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> -60° C
		590	400	36

<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>Nb</b>
	< 0,07	0,8	0,6	19	11	2.6	≥ 8 x C %

**Current** = +

**Welding positions** PA, PB, PC, PD, PE, PF

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

<b>Dia./Length</b>	<b>Amperage (A)</b>	<b>Pcs./packet</b>	<b>Pcs./carton</b>	<b>kg/1000</b>	<b>kg/packet</b>	<b>kg/carton</b>
2,0 x 300	30 - 60	392	1569	10,2	4,0	16,0
2,5 x 300	45 - 80	250	1000	16,0	4,0	16,0
3,2 x 350	60 - 105	159	635	31,5	5,0	20,0
4,0 x 350	100 - 140	105	418	47,8	5,0	20,0
5,0 x 450	120 - 170	63	250	96,0	6,0	24,0

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