

## CARBO S- 4332 CARBO T- 4332

International standards				2	= solid v	wire		T = M	oare roo	4	
		Werksto		Sond		1.4332					
		EN 12072		G 23 12	G 23 12 L Si			W 23 12 L Si			
		AWS A 5.9						309LSi			
Approvals		TÜV				_	TÜV				
Application notes		Wire electrode for joining difficult-to-weld steels and for corrosion-proof plating. An austenitic 18/10 type CrNi weld metal can be obtained already in the first layer. The 4332 alloy is also suitable for buffer layers on plated metal sheets. The highly alloyed weld metal deposited by the CARBO 4332 AC electrode ensures crack-proof welds and is scale-resistant up to 1,000°C. The deposits are capable of taking high polish.									
Operating temperature		- 80 bis + 300° C					- 10 bis + 300° C				
Base materials		Joints of 1.4583 with HI / H II, 17 Mn 4, StE 355. P235GH / P256GH, P295GH, P355N 1.4825 GX25CrNiSi18-9 1.4826 GX40CrNiSi22-9 1.4828 X15CrNiSi20-10 1.4832 GX25CrNiSi20-14 CARBO S-4332 1.4583 with 1.6211 16 MnNi6-3 1.6217 13 MnNi6-3									
Mechanical properties of all-weld metal		Tensile strength R <sub>m</sub> N/mm <sup>2</sup>		Yield strength R <sub>p0,2</sub> N/mm <sup>2</sup>		Elongation A <sub>5</sub> %		Impact strength ISO – V J at 20° C			
( typical values)		550		400		30		55			
Weld metal analysis (typical, wt. %)		<b>C</b> 0,03	<b>Si</b> 0,9	<b>Mn</b> 2,0	<b>Cr</b> 24,0	<b>Ni</b> 13,0					
		S = solid wire					T = bare rod				
Gas types EN 439		M12, M13						11			
Current	Current		= +					= -			
Diameter	mm	0,8	1,0	1,2	1,6	1,6	2,0	2,4	3,2	4,0	
Welding amps	(A) min.	80	120		250						
	(A) max.	130	190	250	320						
coils, weight		B300 1	5 kg.			10 k	g.				

Rev. 001/13

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.