

CARBO S- 4332

CARBO T- 4332

International standards

	S = solid wire	T = bare rod
Werkstoff Nr.	1.4332	
EN 12072	G 23 12 L Si	W 23 12 L Si
AWS A 5.9	ER309LSi	ER309LSi

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

(typical values)

Tensile strength R_m N/mm ²	Yield strength $R_{p0,2}$ N/mm ²	Elongation A_5 %	Impact strength ISO – V J at 20° C
550	400	30	55

Weld metal analysis (typical, wt. %)

C	Si	Mn	Cr	Ni
0,03	0,9	2,0	24,0	13,0

Gas types EN 439

S = solid wire

M12, M13

T = bare rod

I1

Current

Diameter mm
Welding amps (A) min.
(A) max.

= +				= -				
0,8	1,0	1,2	1,6	1,6	2,0	2,4	3,2	4,0
80	120	180	250					
130	190	250	320					

coils, weight

Rev. 001/13

B300 15 kg.

10 kg.