CARBO S-1.4440
CARBO T-1.4440

International standards

	S = solid wire	T = bare rod
Mat. No.	1.4440	
EN 12072	G 18 16 5 NL	W 18 16 5 NL
AWS A 5.9	~ER317L	~ER317L

Application notes

Solid wire electrode for joining corrosion-proof CrNiMo steels of low carbon content as well as stabilised and non-stabilised 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 350° C.

Scale resistant up to 875° C in an air and oxidising gases atmosphere.

No intercrystalline corrosion due to low carbon content.

The deposit is capable of taking high polish.

Also approved for joining austenitic to ferritic steels (weld thin stringer beads)

Welding wire with higher molybdenum content than for ER 316. The reduced carbon content (maximum 0.03%) offers higher resistance to inter-granular corrosion due to carbide precipitation. This welding wire offers has extreme **corrosion resistance** to sulfuric and sulfurous acids and their salts.

Base materials

1.4429	1.4446
1.4432	1.4448
1.4434	

Mechanical properties of all-weld metal

Tensile strength R_m N/mm²	Yield strength $R_{p0,2}$ N/mm²	Elongation A_5 %	Impact strength ISO – V J at - 60° C
520	>320	>30	>80

(typical values)

Weld metal analysis
(typical, wt. %)

C	Si	Mn	Cr	Ni	Mo	N
≤0,025	0,35	3,5	18,5	17,5	4,5	0,15

Gas types EN 439

S = solid wire	T = bare rod
M12	I1

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	180	250					
(A) max.	120	180	230	300					

coils, weight

B300   15 kg.   10 kg.

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