

CARBO S- 1.4462

CARBO T- 1.4462

International standards

	S = solid wire	T = bare rod
W. Nr.	1.4462	
EN ISO 14343	G 22 9 3 N L	W 22 9 3 N L
AWS A 5.9	ER2209	ER2209

Approvals

TÜV

TÜV

Application notes

Solid wire electrode suitable for welding compound steel of the same or similar types. The weld deposit is resistant to pitting, stress corrosion cracking and intercrystalline corrosion at temperatures up to 250°C.

Operating temperature

-40° C up to +250° C

Base materials

1.4347	GX8CrNiN26-7	1.4462	X2CrNiMoN22-5-3
1.4362	X2CrNiN23-4	1.4463	GX 6 CrNiMo 24-8-2
1.4417	GX2CrNiMoN25-7-3	1.4575	X1CrNiMoNb28-4-2
1.4426	GX10CrNiMoN15-4-2	1.4582	X4CrNiMoNb 25-7
1.4460	X3CrNiMoN27-5-2		

Joints of: 1.4462 with 1.4583 and

1.4462 with H I / H II, 17 Mn 4, 15 Mo 3, StE 255 up to StE 355

P235GH / P256GH, P295GH, 16Mo3, P255N up to P355N

Mechanical properties of all-weld-metal

(typical values)

Tensile strength R_m N/mm ²	Yielding strength $R_{p0,2}$ N/mm ²	Elongation A_5 %	Impact strength ISO – V J at RT° C
680	480	22	50

Weld metal analysis

(typical, wt %)

C	Si	Mn	Cr	Ni	Mo	N
0,025	0,5	1,6	23,0	9,0	3,0	0,14

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. 002/13

B300 15 kg.

10 kg.