

CARBO S- 4519

CARBO T- 4519

International standards

	S = solid wire	T = bare rod
Werkstoff Nr.	1.4519	
EN 12072	G 20 25 5 Cu L	W 20 25 5 Cu L
AWS A 5.9	ER 385	ER 385

Application notes

High alloyed wire electrode which is well suited for joint welding on the same or similar corrosion resistant CrNiMoCu steels along with low alloyed steels.

Overlays with this electrode leave a pierce and tension resistant deposit that is also resistant to intergranular (IK) corrosion, specifically from acids and non-oxidating materials (i.e. sulphuric, phosphorous acids or ammonium acetate).

Operating temperature

up to 350°C

Base material

1.4339	GX32CrNi28-10	1.4536	GX 2 NiCrMoCuN 20-18
1.4500	GX7NiCrMoCuNb25-20	1.4539	X 1 NiCrMoCu25-20-5
1.4505	X4NiCrMoCuNb20-18-2	1.4585	GX7CrNiMoCuNb18-18
1.4506	X5NiCrMoCuTi20-18	1.4586	X5NiCrMoCuNb22-18
1.4531	GX2NiCrMoCuN20-18		

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	350	35	55

Weld metal analysis

(typical, wt. %)

C	Si	Mn	Cr	Ni	Mo	Cu
<0,025	0,20	2,5	20,5	25	4,8	1,5

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.