

CARBO S-4842 CARBO T- 4842

International standard	S	S = solid v	vire	T = bare rod	
	Mat. No.				
	EN 12072	G 25 20	W 25	20	
	AWS A 5.9	~ER310	~ER3	310	
Application notes	Solid wire electrode for joining corrosion-proof, highly heat-proof and non-scaling CrNi-steels which are subject to service temperatures up to 1200° C. The electrode is also suitable for joint welding Cr-, CrSi-, and CrAl steels and for cladding low alloy base metals. The weld metal alloy is highly hot-crack-proof. Keep temperature as low as possible during welding.				
	Annealing to 250°C and post-weld tempering to 700°C is required on ferritic base materials. The electrode is mainly used in furnace-construction, for fittings and				
Operating temperature	+20° C bis +11	50° C			
Base materials	1.4713 X10C 1.4762 X10C 1.4825 GX25 1.4826 GX40	1.4710GXCrSi61.4832GX25CrNiSi20-121.4713X10CrAl71.4841X15CrNiSi25-201.4762X10CrAi241.4845X12CrNi25-211.4825GX25CrNiSi18-91.4846GX40CrNiSi25-211.4826GX40CrNiSi22-91.4848GX40 CrNiSi25-201.4828X15CrNiSi20-121.4848GX40 CrNiSi25-20			
Mechanical properties of all-weld metal	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	
(typical values)	550	320	25	80	
Weld metal analysis (typical, wt. %)	CSi0,131,0	Mn Cr 3,2 25,0	Ni 20,5		
	S = s	S = solid wire		T = bare rod	
Gas types EN 439	M13			11	
Current Diameter mm Welding amps (A) min. (A) max		180 250	1,6 2,0	= – 2,4 3,2 4,0	
coils, weight Rev. 001/13	B300 15 kg.		10 kg.		

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.