

International standards	Material No.	1.4850
	EN ISO 3581-A	E 22 33 Nb B 22

Approvals --

Typical applications and characteristics CARBO 4850 B is a lime basic coated electrode with an alloyed core, suitable for joint welding on equivalent or similar corrosion and heat resistant steels and cast steels.
The deposits are scale resistant up to 1050°C and have good resistance to carburising atmospheres, hot air, oxidising combustion gases or reducing combustion gases

Operating temperature Rt. up to 1050° C

Structure Austenite

Base materials	1.4845	X12CrNi25-21	1.4865	GX40NiCrSi38-18
	1.4849	GX40NiCrSiNb38-18	1.4876	X10NiCrAlTi32-20 (Alloy 800)
	1.4859	GX10NiCrNb32-20	1.4861	X10NiCr32-20
	1.4958	X5NiCrAlTi31-20	1.4864	X12NiCrSi36-16
	1.4959	X8NiCrAlTi32-21		(Alloy 800 H)

Mechanical properties of all-weld metal (typical values)	Tensile strength R_m N/mm ²	Yield strength R_{p0,2} N/mm ²	Elongation A₅ %	Impact strength ISO – V J at room temperature
	600	380	25	45

Weld metal analysis (typical, wt %)	C	Si	Mn	Cr	Ni	Nb
	0,15	0,6	3,5	21	33	1,5

Current = +

Welding positions PA, PB, PC, PD, PE, PF

Rebaking 1 h, 350° C + / - 10° C (if necessary)

Dia./Length	Amperage (A)	Pcs./packet	Pcs./carton	kg/1000	kg/packet	kg/carton
2,5 x 300	50 - 70	225	899	17,8	4,0	16,0
3,2 x 350	60 - 110	143	571	35,0	5,0	20,0
4,0 x 350	90 - 140	94	377	53,1	5,0	20,0

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