

# CARBO S- 4316 Si

# CARBO T- 4316

## International standards

	S = solid wire	T = bare rod
Werkstoff Nr.	1.4316	
EN 12072	G 19 9 L Si	W 19 9 L Si
AWS A 5.9	ER308LSi	ER308LSi

## Approvals

TÜV, DB, CE

TÜV, DB, CE

## Application notes

Solid wire electrode for joining corrosion-proof CrNi steels with 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 and is scale resistant up to 875°C in an air and oxidising gases atmosphere. No intercrystalline corrosion due to low carbon content.

The deposits are capable of taking high polish.

## Operating temperature

-196° C bis +350° C

## Base materials

1.4306 X2CrNi19-11	1.4312 GX10CrNi18-10
1.4311 X2CrNi18-10	1.4541 X6CrNiTi18-10
1.4300 X 12 CrNi 18 8	1.4550 X6CrNiTi18-10
1.4301 X5CrNi18-10	1.4552 GX5CrNiNb19-11
GX5CrNi19-10	

## Mechanical properties of all-weld metal

( typical values)

Tensile strength $R_m$ N/mm <sup>2</sup>	Yield strength $R_{p0,2}$ N/mm <sup>2</sup>	Elongation $A_5$ %	Impact strength ISO – V J at 20° C
550	320	35	70

## Weld metal analysis

(typical, wt. %)

C	Si	Mn	Cr	Ni
0,02	0,9	1,7	20	10

## Gas types EN 439

S = solid wire  
M11, M12, M13

T = bare rod  
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.	130	190	250	320					

## coils, weight

Rev. 001/13

B300 15 kg.

10 kg.