

CARBO S- 4842

CARBO T- 4842

International standards

	S = solid wire	T = bare rod
Mat. No.	1.4842	
EN 12072	G 25 20	W 25 20
AWS A 5.9	~ER310	~ER310

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 +1150° C

Base materials

1.4710	GXCrSi6	1.4832	GX25CrNiSi20-12
1.4713	X10CrAl7	1.4841	X15CrNiSi25-20
1.4762	X10CrAl24	1.4845	X12CrNi25-21
1.4825	GX25CrNiSi18-9	1.4846	GX40CrNiSi25-21
1.4826	GX40CrNiSi22-9	1.4848	GX40 CrNiSi25-20
1.4828	X15CrNiSi20-12		

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	320	25	80

Weld metal analysis

(typical, wt. %)

C	Si	Mn	Cr	Ni
0,13	1,0	3,2	25,0	20,5

Gas types EN 439

S = solid wire

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.