CARBO 4842 B

International standards	Material No.	1.4842
	EN ISO 3581-A	E 25 20 B 22
	AWS A 5.4	E310-15

Approvals --

Typical applications and characteristics

CARBO 4842 B is an basic-coated electrode with an alloyed core, suitable 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 pipelines.

Operating temperature From room temperature up to + 1200° C

Base materials

1.4710	GX30CrSi6	1.4832	GX 25CrNiSi20-14
1.4713	X10CrAl7	1.4841	X15CrNiSi25-20
1.4762	X10CrAl24	1.4845	X12CrNi25-21
1.4825	GX25CrNiSi18-9	1.4846	GX40 CrNiSi25-21
1.4826	GX40CrNiSi22-9	1.4848	GX40CrNiSi25-20
1.4828	X15CrNiSi20-12		

Mechanical properties of all-weld metal (typical values)

Tensile strength R_m N/mm²	Yield strength $R_{p0,2}$ N/mm²	Elongation A_5 %	Impact strength ISO – V J at room temperature
600	350	30	90

Weld metal analysis (typical, wt %)

C	Si	Mn	Cr	Ni
0,10	0,6	3	25	21

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 - 75	267	1067	15,0	4,0	16,0
3,2 x 350	75 - 110	169	676	29,6	5,0	20,0
4,0 x 350	100 - 145	112	446	44,8	5,0	20,0
5,0 x 450	120 - 165	67	267	90,0	6,0	24,0

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