

CARBO 4576 MPR

International Standards

Material No.	1.4576
EN ISO 3581-A	E 19 12 3 Nb R 53
AWS A 5.4	E318-26

Approvals

Typical applications and characteristics

CARBO 4576 MPR is a high recovery electrode (160%) for AC-welding, suitable for joining corrosion-proof CrNiMo-steels as well as stabilized and non-stabilized base materials of same or similar characteristics which are resistant to chemical agents. Combined with a base material of same characteristics the weld metal is resistant to wet corrosion up to 400°C. The weld metal alloy is scale-resistant up to 875°C in air and in oxidizing gases atmosphere.

Operating temperature

- 60°C up to + 400°C

Base materials

1.4401 X5CrNiMo17-12-2	1.4571 X6CrNiMoTi17-12-2
1.4436 X3CrNiMo17-13-3	1.4579 X6CrNiMoTi17-12-2
1.4437 GX6CrNiMo18-12	1.4580 X6CrNiMoNb17-12-2
1.4408 GX5CrNiMo19-11-2	1.4583 (G)X10CrNiMoNb18-12

Mechanical properties of all-weld metal (typical values

Tensile strength Rm N/mm ²	Yield strenght R _{p0,2} N/mm ²	Elongation A5 %	Impact strenght ISO-V at - 60°C
590	400	36	>32

Weld metal analysis (typical, wt %)

C	Si	Mn	Cr	Ni	Mo	Nb
< 0,07	0,8	0,6	19	11	2,6	≥8 x C%

Current

= + / ~ , 50 V

Welding positions

PA, PB

Rebaking

1 h, 350°C + / - 10°C (if necessary)

Dia./Length	Amperage (A)	Pcs./packet	Pcs./carton	kg /1000 pcs.	kg / packet	kg / carton
2,0 x 300	50 - 90	238	952	16,8	4,0	16,0
2,5 x 300	80 - 100	163	611	26,2	4,0	16,0
3,2 x 350	90 - 130	97	388	51,6	5,0	20,0
4,0 x 350	130 - 180	64	256	78,2	5,0	20,0
5,0 x 450	130 - 170	38	152	157,0	6,0	24,0