# CARBO WELD
SCHWEISSMATERIALIEN GMBH

# CARBO 4332 AC

| **International standards** | Material No. | 1.4332 |
|---|---|---|
| | EN ISO 3581-A | E 23 12 L R 12 |
| | AWS A 5.4 | E309L-17 |

**Approvals**  TÜV

**Characteristics and typical applications**

CARBO 4332 AC is an AC-weldable, rutile-coated electrode with an alloyed core, suitable for joining difficult-to-weld steels and for corrosion-proof plating.
An austenitic 18/10 type CrNi weld metal can be obtained already in the first layer.
The 4332 alloy is also suitable for buffer layers on plated metal sheets.
The highly alloyed weld metal deposited by the CARBO 4332 AC electrode ensures crack-proof welds and is scale-resistant up to 1,000°C.

**Operating temperature**  - 60° C up to +300° C

**Base materials**

Combined compound of 1.4583 with HI / H II, 17 Mn 4, StE 355.
1.4583 with P235GH / P256GH, P295GH, P355N

1.4825   GX25CrNiSi18-9
1.4826   GX40CrNiSi22-9
1.4828   X15CrNiSi20-10
1.4832   GX25CrNiSi20-14

1.4301   X5CrNi18-10 for cladding

**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 - 120° C |
|---|---|---|---|
| 590 | > 400 | > 32 | > 32 |

**Weld metal analysis %**
(typical)

| C | Si | Mn | Cr | Ni |
|---|---|---|---|---|
| < 0,04 | 0,9 | 0,7 | 24 | 13 |

**Current**  **= + / ~** , 42 V

**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 |
|---|---|---|---|---|---|---|
| 2,0 x 300 | 30 -  60 | 342 | 1368 | 11,7 | 4,0 | 16,0 |
| 2,5 x 300 | 40 -  75 | 219 | 874 | 18,3 | 4,0 | 16,0 |
| 3,2 x 350 | 75 - 110 | 139 | 556 | 36,0 | 5,0 | 20,0 |
| 4,0 x 350 | 90 - 140 | 92 | 366 | 54,0 | 5,0 | 20,0 |
| 5,0 x 450 | 130 - 170 | 55 | 219 | 109,7 | 6,0 | 24,0 |

Rev. 001/12