

# CARBO 4430 FALL

International standards	Material No.	1.4430
	EN ISO 3581-A	E 19 12 3 L R 11
	AWS A 5.4	E316L-17

**Approvals** ---

**Typical applications and characteristics** CARBO 4430 FALL is a very thinly rutile-basic coated electrode with an alloyed core, suitable for joining corrosion-proof CrNiMo stainless steels with low-carbon content as well as stabilised and non-stabilised base materials of same or similar type which are subject to service temperatures from – 60° C up to 400° C, as used in the chemical and petrochemical industries, in refineries, etc.  
The electrode is especially designed for welding in **VERTICAL DOWN POSITION (PG)**.  
The alloy is non-scaling up to 875° C in air and oxidising gases atmosphere. No risk of intercrystalline corrosion due to the low C-content.  
The weld metal is capable of taking a high polish.

**Operating temperature** - 60° C up to + 400° C

<b>Base materials</b>	1.4404 X2CrNiMo17-13-2	1.4437 GX6CrNiMo18-12
	1.4435 X2CrNiMo18-14-3	1.4408 GX5CrNiMo19-11-2
	1.4409 GX2CrNiMo19-11-2	1.4571 X6CrNiMoTi17-12-2
	1.4429 X2CrNiMoN17-13-3	1.4580 X6CrNiMoNb17-12-2
	1.4401 X5CrNiMo17-12-2	1.4581 GX5CrNiMoNb19-11-2
	1.4436 X3CrNiMo17-13-3	1.4583 (G)X10CrNiMoNb18-12

<b>Mechanical properties of all-weld metal</b> ( typical values)	<b>Tensile strength</b> R <sub>m</sub> N/mm <sup>2</sup>	<b>Yield strength</b> R <sub>p0,2</sub> N/mm <sup>2</sup>	<b>Elongation</b> A <sub>5</sub> %	<b>Impact strength</b> ISO – V J at room temperature
	550	360	39	75

<b>Weld metal analysis</b> (typical, wt. %)	<b>C</b>	<b>Si</b>	<b>Mn</b>	<b>Cr</b>	<b>Ni</b>	<b>Mo</b>
	< 0,03	0,7	0,7	19	12	2,8

**Current** = + / ~ / 50 V

**Welding positions** PA, PB, PC, PD, PE, PF, PG

**Rebaking** 1 h, 350° C + / - 10° C ( if required )

Dia./Length	Amperage (A)	Pcs./packet	Pcs./carton	kg/1000	kg/packet	kg/carton
2,0 x 300	40 - 50	385	1538	10,4	4,0	16,0
2,5 x 300	50 - 70	247	988	16,2	4,0	16,0
3,2 x 350	70 - 90	156	625	32,0	5,0	20,0

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