

CARBO S- 4576 Si

CARBO T- 4576 Si

International standards

Mat. No.	S = solid wire	T = bare rod
	EN 12072	G 19 12 3 Nb Si
AWS A 5.9	ER318Si	ER318Si
DIN 8556	SG X5 CrNiMoNb 19 12 3	SG X5 CrNiMoNb 19 12 3

Approvals

TÜV, DB, CE

TÜV, DB, CE

Application notes

High alloyed stabilised CrNiMoNb wire/rod electrode for joining corrosion-resistant stabilised and non-stabilised CrNiMo steels of identical or similar characteristics which are resistant to chemical agents. For service temperatures up to 400 °C. Non scaling up to +800°C.

Operating temperature

-60° C bis +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 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	380	30	70

Weld metal analysis (typical, wt. %)

C	Si	Mn	Cr	Ni	Mo	Nb
0,05	0,8	1,5	19	12	2,8	12 x % C

Gas types EN 439

S = solid wire
M11, M12, M13

T = bare rod
I1

Current

Diameter mm	= +				= -				
	0,8	1,0	1,2	1,6	1,6	2,0	2,4	3,2	4,0
Welding amps (A) min.	80	120	180	250					
(A) max.	130	190	250	320					

coils, weight

Rev. 001/13

B300 15 kg.

10 kg.