

CARBO 4332 MPR

International Standards

Material No.	1.4332
EN ISO 3581-A	E 23 12 L R53
AWS A 5.4	E309L-26

Approvals

Typical applications and characteristics

CARBO 4332 MPR is an AC-weldable, rutile-coated electrode with a recovery of 160 %, 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/mm ²	Yield strength R _{p0,2} N/mm ²	Elongation A5 %	Impact strength ISO-V at - 60°C
590	>400	>32	>32

Weld metal analysis (typical, wt %)

C	Si	Mn	Cr	Ni
≤ 0,04	0,9	0,7	24,0	13,0

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
2,5 x 350	50 - 100	163	651	30,7	5,0	20,0
3,2 x 350	80 - 130	96	385	51,9	5,0	20,0
4,0 x 450	110 - 180	59	238	101,0	6,0	24,0
5,0 x 450	170 - 240	38	152	157,8	6,0	24,0