CARBO WELD®
SCHWEISSMATERIALIEN GMBH

CARBO 4410 AC

International Standards

Material No.	~1.4410
EN ISO 3581-A	E 25 9 4 N L R 32
AWS A 5.4	E2594-16

Approvals

Typical applications and characteristics

CARBO 4410 AC is an AC-weldable electrode with an alloyed core, suitable for welding on Duplex- and Super-Duplex-steels of same or similar steels. The duplex weld deposit provides exellent resistant to pitting, chloride stress corrosion cracking and intercrystalline corrosion due to the high CrMo(N) content (PReN - Pitting index ≥40).
Furthermore, the weld metal alloy is saltwater-proof and performs high tensile strength, as a result of nitrogen being added to the alloy.

Operating temperature

-40°C up to 250°C

Base materials

1.4410 X2 CrNiMoN25-7-4
1.4462 X2 CrNiMoN22-5-3
1.4468 GX2 CrNiMoN25-6-3
1.4469 GX2 CrNiMoN26-7-4
Zeron 100
1.4501 X2 CrNiMoCuWN25-7-4
1.4508 GX2 CrNiMoCuWN25-8-4
1.4515 GX2 CrNiMoCuN26-6-3
1.4517 GX2 CrNiMoCuN25-6-3-3

Mechanical properties of all-weld metal (typical values

Tensile strength Rm N/mm²	Yield strenght $R_{p0,2}$ N/mm²	Elongation A5 %	Impact strenght DVM J at - 40°C	Impact strenght DVM J at - 46°C
850	700	30	>40J	>27J

Weld metal analysis (typical, wt %)

C	Si	Mn	Cr	Ni	Mo	N
≤ 0,03	0,6	0,8	25,5	9,5	4,0	0,25

Current

= + / ~ , 42 V

Welding positions

PA, PB, PC, PD, PE, PF

Rebaking

2 h, 250° C + / - 10° C (if nacessary)

Dia./Length	Amperage (A)	Pcs./packet	Pcs./carton	kg /1000 pcs.	kg / packet	kg / carton
2,5 x 300	50 - 80	221	884	18,1	4,0	16,0
3,2 x 350	70 - 110	140	559	35,8	5,0	20,0
4,0 x 350	90 - 140	92	369	54,2	5,0	20,0

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