CARBO WELD
SCHWEISSMATERIALIEN GMBH

CARBO 4576 AC

International standards

Material No.	1.4576
EN ISO 3581-A	E 19 12 3 Nb R 12
AWS A 5.4	E318-17

Approvals

TÜV, DB, CE

Typical applications and characteristics

CARBO 4576 AC is an AC-weldable, rutile-coated electrode with an alloyed core, suitable for joining corrosion-proof CrNiMo-steels as well as stabilized and non-stabilized base materials of same or similar characteristics which are resistant to chemical agents.
Combined with a base material of same characteristics the weld metal is resistant to wet corrosion up to 400°C.
The weld metal alloy is scale-resistant up to 875°C in air and in oxidizing gases atmosphere.

Operating temperature

- 60° C up to + 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/mm²	Yield strength $R_{p0,2}$ N/mm²	Elongation A_5 %	Impact strength ISO – V J -60° C
590	400	36	57

Weld metal analysis (typical, wt %)

C	Si	Mn	Cr	Ni	Mo	Nb
< 0,07	0,8	0,6	19	11	2.6	≥ 8 x C %

Current

= + / ~ / 50 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	35 - 55	345	1379	11,6	4,0	16,0
2,5 x 300	55 - 75	221	884	18,1	4,0	16,0
3,2 x 350	70 - 105	140	559	35,8	5,0	20,0
4,0 x 350	100 - 140	92	369	54,2	5,0	20,0
4,0 x 450	100 - 140	86	345	69,6	6,0	24,0
5,0 x 450	130 - 170	55	221	108,8	6,0	24,0

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