

CARBO 4316 MPR

International standards	Material No.	1.4316
	EN 1600	E 19 9 L R 53
	AWS A 5.4	E308L-17

Approvals ---

Typical applications and characteristics

CARBO 4316 MPR is an AC-weldable, rutile coated electrode with a recovery of 160 % suitable for joining corrosion-proof CrNi steels with low carbon content as well as stabilised and non-stabilised steels of identical or similar characteristics which are resistant to chemical agents. Used on a base metal of identical characteristics the weld metal is resistant to wet corrosion up to 350° C.

CARBO 4316 MPR is scale resistant up to 875°C in an air and oxidising gases atmosphere. No intercrystalline corrosion due to low carbon content.

The weld metal is capable of taking high polish.

Operating temperature -60° C up to +350° C

Base materials	1.4306 X2CrNi19-11	1.4312 GX10CrNi18-10
	1.4311 X2CrNi18-10	1.4541 X6CrNiTi18-10
	1.4300 X 12 CrNi 18 8	1.4550 X6CrNiTi18-10
	1.4301 X5CrNi18-10	1.4552 GX5CrNiNb19-11
	1.4308 GX5CrNi19-10	

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 - 120° C
530	320	> 35	> 32

Weld metal analysis % (typical)

C	Si	Mn	Cr	Ni
< 0,04	0,9	0,8	20	10

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	kg/packet	kg/carton
2,0 x 300	40 - 75	238	952	16,8	4,0	16,0
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 - 250	38	152	157,8	6,0	24,0