

CARBO 4551 AC

International standards	Material No.	1.4551
	EN 1600	E 19 9 Nb R 12
	AWS A 5.4	E347L-17

Approvals TÜV, DB, Ü, UDT

Characteristics and typical applications CARBO 4551 AC is an AC-weldable, rutile coated electrode with an alloyed core, suitable for joining corrosion-proof stabilized or unstabilized CrNi 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 400° C. The deposit is scale resistant up to 800°C in an air and oxidising gases atmosphere.

Operating temperature -60° C up to +400° C

Base materials	1.4300 X 12 CrNi 18 8	1.4541 X6CrNiTi18-10
	1.4301 X5CrNi18-10	1.4550 X6CrNiTi18-10
	.4308 GX5CrNi19-10	1.4552 GX5CrNiNb19-11
	.4312 GX10CrNi18-10	

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
	600	400	40	53

Weld metal analysis (typical, wt %)	C	Si	Mn	Cr	Ni	Nb
	0,06	0,9	0,7	20	10	≥ 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 pcs.	kg/packet	kg/carton
2,0 x 300	25 - 55	345	1379	11,6	4,0	16,0
2,5 x 300	40 - 80	221	884	18,1	4,0	16,0
3,2 x 350	65 - 110	140	559	35,8	5,0	20,0
4,0 x 350	100 - 140	92	369	54,2	5,0	20,0
5,0 x 450	120 - 170	55	221	108,8	6,0	24,0