

<b>International standards</b>	Material No.	1.4850
	EN 1600	E 22 33 Nb B 22

**Approvals** --

**Typical applications and characteristics** CARBO 4850 B is a lime basic coated electrode with an alloyed core, suitable for joint welding on equivalent or similar corrosion and heat resistant steels and cast steels.  
The deposits are scale resistant up to 1050°C and have good resistance to carburising atmospheres, hot air, oxidising combustion gases or reducing combustion gases

**Operating temperature** Rt. up to 1050° C

**Structure** Austenite

**Base materials**

1.4845 X12CrNi25-21	1.4865 GX40NiCrSi38-18
1.4849 GX40NiCrSiNb38-18	1.4876 X10NiCrAlTi32-20 (Alloy 800)
1.4859 GX10NiCrNb32-20	1.4861 X10NiCr32-20
1.4958 X5NiCrAlTi31-20	1.4864 X12NiCrSi36-16
1.4959 X8NiCrAlTi32-21	(Alloy 800 H)

**Mechanical properties of all-weld metal**  
( typical values )

Tensile strength $R_m$ N/mm <sup>2</sup>	Yield strength $R_{p0,2}$ N/mm <sup>2</sup>	Elongation $A_5$ %	Impact strength ISO - V J at room temperature
600	380	25	45

**Weld metal analysis**  
(typical, wt %)

C	Si	Mn	Cr	Ni	Nb
0,15	0,6	1,6	21	33	1,2

**Current** = +

**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
2,5 x 300	50 - 70	225	899	17,8	4,0	16,0
3,2 x 350	60 - 110	143	571	35,0	5,0	20,0
4,0 x 350	90 - 140	94	377	53,1	5,0	20,0

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