

## **CARBO 4853 B**

International standards	Material	No.	1.4853					
	EN ISO	3581-A	E 25 35 Nb B 22					
Approvals								
Typical applications and characteristics	CARBO 4853 B is a lime basic coated electrode with an alloyed core, suitable for fabrication welding and claddings on equivalent or similar corrosion and heat resistant steels and centrifugal castings. The deposits are applied on centrifugally cast tubes as well as on parts of reformer- and industrial furnaces where high heat and scale resistant under mechanical, thermal and corrosive load is essential. The scaling resistance is guaranteed up to 1050°C. Creep rupture reaches values up to 80% of the base material HP. Further the alloy has a good resistance to carburisation and sulphuric gases							
Operating temperature	Rt. up to 1050° C							
Structure	Austenit	e						
Base materials	1.4852	GX40 NiCrSiNt	035-25	1.4857	GX40NiCrSi35-25			

Mechanical properties of all-weld metal ( typical values )	Tensile strength R <sub>m</sub> N/mm²		Yield strength R <sub>p0,2</sub> N/mm²			Elongation A₅ %			
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Weld metal analysis	С	Si	Mn	Р	S	Cr	Ni	Nb	
(typical, wt %)	0,4	1,0	2	0,02	0,006	24,5	35	1,3	
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	231	925	17,3	4,0	16,0
3,2 x 350	70 - 100	147	588	34,0	5,0	20,0
4,0 x 350	80 - 120	97	388	51,5	5,0	20,0
5,0 x 450	110 - 160	58	232	103,5	5,0	20,0

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Statements on composition and application are just for the applier's information. Statements on mechanical properties always refer to the all-weld-metal according to valid standards. Carbo-Weld may change the characteristics of its products without notice. We recommend the applier to check our products for their special application autonomously.