

CARBO 4462 Cu AC

International standards	Material No.	1.4462 similar			
	EN ISO 3581-A	E 25 9 3 Cu N L R 12			
	DIN 8555	E9-UM-300-CKR			

Approvals

Typical applications
and characteristicsCARBO 4462 Cu AC is an AC-weldable electrode with an alloyed core,
suitable for corrosion resistant platings.
The weld deposit is resistant to pitting, stress corrosion cracking and in-
tercrystalline corrosion at temperatures up to 250° C.
Furthermore, the weld metal alloy is saltwater-proof and performs high
tensile strength, as a result of nitrogen being added to the alloy.
The deposits give better corrosion results than the Cu free version.

Operating temperature - 40° C up to + 250° C

Mechanical properties of all-weld metal	Tensile strength R _m N/mm ²	Yield strength R _{p0,2} N/mm ²	Elongation A₅ %	Impact strength ISO – V J - 40° C	Hardness HB	
(typical values)	850	700	30	>32	ca.300	

Weld metal analysis	С	Si	Mn	Cr	Ni	Мо	Ν	Cu	
(typical, wt %)	0,03	0,8	0,7	25	9	4	0,2	2,5	
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
2,5 x 300	40 - 70	221	884	18,1	4,0	16,0
3,2 x 350	60 - 110	140	559	35,8	5,0	20,0
4,0 x 350	90 - 145	92	369	54,2	5,0	20,0

Rev. 001/12

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.