

CARBO S- 4337

CARBO T- 4337

International standards

	S = solid wire	T = bare rod
Mat. No.	1.4337	
EN 12072	G 29 9	W 29 9
AWS A 5.9	~ ER312	~ ER312

Application notes

Solid wire electrode for joining difficult-to-weld steels.
Austenitic-ferritic stainless steel welding deposit (high ferrite content).
The weld metal remains ferritic, even after dilution with an austenitic base metal forming elements such as Mn, Ni und C and is thus highly crack resistant. Plastic weld metal of high tensile strength, impact proof, tough, and acid and heat resistant up to 1,000° C.
Hardness after strain-hardening: ca. 360 HB
Soft, intense fusion, easy slag removal, finely rippled beads.

Operating temperature

up to + 300° C

Base materials

Difficult-to-weld base materials such as: high-carbon steel, tool steel, spring steel, manganese steel, case-hardening steel, high-speed steels, cast steels, screening steels, Suitable for joining these materials to each other or to dissimilar steels. Also suitable for surfacing and repair welding rails, shafts, couplings, impellers, hot work tools, pressing and trimming tools, as well as stamping dies.

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 20° C
750	500	20	25

Weld metal analysis (typical, wt. %)

C	Si	Mn	Cr	Ni
0,15	0,5	1,6	30	9

Gas types EN 439

S = solidwire
M12, M13

T = bare rod
I1

Current

		= +				= -				
Diameter	mm	0,8	1,0	1,2	1,6	1,6	2,0	2,4	3,2	4,0
Welding amps	(A) min.	80	120	180	250					
	(A) max.	130	190	250	320					

coils, weight

Rev. 001/13

B300 15 kg.

10 kg.