

## CARBO S-1.4459 CARBO T-1.4459

International standards		S = solid wire	T = bare rod
	Mat. No.	1.	4459
	EN 12072	G 23 12 2 L	W 23 12 2 L
	AWS A 5.9	ER309LMo	ER309LMo

Application notes A continuous, solid, corrosion-resistant, chromium-nickel-molybdenum wire for the GMA welding of stainless steel. CARBO S-1.4459 has good resistance to general corrosion. The alloy is often used for joining stainless steels to non-alloy or low-alloy steels where corrosion resistance is of less importance. CARBO S-1.4459 is usually welded with Ar/(1-3%) O2 as the shielding gas.

Base materials	1.4583 with H I / H II, 17 Mn 4, StE 355.
	P235GH / P256GH, P295GH, P355N
	1.4401 X 5 CrNiMo 17 12 3
	1.4404 X 2 CrNiMo 17 13 2

Mechanical pro of all-weld met	operties al	Tensile strength R <sub>m</sub> N/mm <sup>2</sup>		Yield strength R <sub>p0,2</sub> N/mm <sup>2</sup>		EI	Elongation A₅ %		Impact strength ISO – V J at 20° C			
(typical values)	1	550		320			35		70			
						1						
Weld metal and	alysis	С	Si	Mn	Cr	Ni		Мо				
(typical, wt. %)		0,02	0,35	1,5	22	14		2,6				
Gas types EN	439	<b>S = solid wire</b> M13				T = bare rod I1						
Current		= +							= -			
Diameter	mm	0,8	1,0	1,2	2 1,6	i	1,6	2,0	2,4	3,2	4,0	
Welding amps ( (	(A) min.	80	120	18	0 250	)						
	(A) max.	130	190	25	0 320	)						
coils, weight Rev. 001/13		B300	15 kg.				10 kg.					

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.