

CARBO S- 1.4462 CARBO T- 1.4462

International standards		S	= solid wi	ire	T	= bare rod		
	W. Nr.		1.4462					
	EN ISO 1434	3 G 22 9	3 N L	W	22 9 3 1	۱L		
	AWS A 5.9	ER220	9	ER	2209			
Approvals	TÜV		ΤÜV					
Application notes	Solid wire electrode suitable for welding compound steel of the same or similar types. The weld deposit is resistant to pitting, stress corrosion cracking and intercrystalline corrosion at temperatures up to 250°C.							
Operating temperature	-40° C up to +250° C							
Base materials	1.4347 GX8CrNiN26-7 1.4462 X2CrNiMoN22-5-3 1.4362 X2CrNiN23-4 1.4463 GX 6 CrNiMo 24-8-2 1.4417 GX2CrNiMoN25-7-3 1.4575 X1CrNiMoNb28-4-2 1.4460 GX10CrNiMoN15-4-2 1.4582 X4CrNiMoNb 25-7 1.4460 X3CrNiMoN27-5-2 1.4582 X4CrNiMoNb 25-7 Joints of: 1.4462 with 1.4583 and 1.4462 with H I / H II, 17 Mn 4, 15 Mo 3, StE 255 up to StE 355 P235GH / P256GH, P295GH, 16Mo3, P255N up to P355N							
Mechanical properties of all-weld-metal	Tensile strenç R _m N/mm²	jth Yield R _i	h Yielding strength R _{p0,2} N/mm ²		tion ⁄₀	Impact strength ISO – V J at RT° C		
(typical values)	680		480		22		50	
		T.		T			,	
Weld metal analysis	C Si	Mn	Cr	Ni Mo	N			
(typical, wt %)	0,025 0,5	1,6	23,0	9,0 3,0	0,14			
	S = solid wiro				T = baro rod			
Gas types FN 439		2 M13						
	111	12, 10110						
Current		= +			=	-		
Diameter mm	0,8 1,0) 1,2	1,6	1,6 2,	02,4	4 3,2	4,0	
Welding amps (A) min.	80 12	0 180) 250					
(A) max.	130 19	U 250) 320					
coils, weight Rev. 002/13	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.