

## CARBO S- 4519 CARBO T- 4519

International s				S = s	olid wire	е	e T=k			bare rod		
		Werksto	off Nr.				1.4519					
		EN 120	72	G 20	3 20 25 5 Cu L			W 20 25 5 Cu			I L	
		AWS A	5.9	ER 385				ER 385				
Application notes		High alloyed wire electrode which is well suited for joint welding on the same or similar corrosion resistant CrNiMoCu steels along with low alloyed steels. Overlays with this electrode leave a pierce and tension resistant deposit that is also resistant to intergranular (IK) corrosion, specifically from acids and non-oxidating materials (i.e. sulphuric, phosphorous acids or ammonium acetate).										
Operating temperature		up to 350°C										
Base material		1.4339 GX32CrNi28-10 1.4536 GX 2 NiCrMoCuN 20-18   1.4500 GX7NiCrMoCuNb25-20 1.4536 GX 2 NiCrMoCuN 20-18   1.4505 X4NiCrMoCuNb20-18-2 1.4585 GX7CrNiMoCuNb18-18   1.4531 GX2NiCrMoCuN20-18 1.4586 X5NiCrMoCuNb22-18										
Mechanical properties of all-weld metal ( typical values)		Tensile strength R <sub>m</sub> N/mm²		Yield strength R <sub>p0,2</sub> N/mm <sup>2</sup>			Elongation A <sub>5</sub> %		Impact strength ISO – V J at 20° C			
		550		350			35		55			
L												
Weld metal analysis		С	Si	Mn	Cr	Ni	Мо	Cu				
(typical, wt. %)		<0,025	0,20	2,5	20,5	25	4,8	1,5				
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Gas types EN 420		S = solid wire					I = bare rod					
Gas เypes EN 439		1112, 1113							11			
Current			=	= +					=			
Diameter Welding amps	mm	0,8	1,0	1	,2	1,6	1,6	2,0	2,4	3,2	4,0	
	(A) min.	80	120	18	80	250						
	(A) max.	130	190	2	50	320						
coils, weight Rev. 001/13		B300 1	5 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.