

CARBO S- 4853

CARBO T- 4853

International standards

	S = solid wire	T = bare rod
Mat. No.	1.4853	
EN 12072	G Z25 35	W Z25 35

Approvals

Application notes

Solid wire electrode suitable for fabrication welding and claddings on equivalent or similar corrosion and heat resistant steels and centrifugal castings.

The deposits are applied on centrifugally cast tubes as well as on parts of reformer- and industrial furnaces where high heat and scale resistant under mechanical, thermal and corrosive load is essential.

The scaling resistance is guaranteed up to 1050°C. Creep rupture reaches values up to 80% of the base material HP.

Further the alloy has a good resistance to carburisation and sulphuric gases

Operating temperature

Rt. up to 1050° C

Structure

Austenite

Base materials

1.4852 GX40 NiCrSiNb35-25

1.4857 GX40NiCrSi35-25

Mechanical properties of all-weld-metal

(typical values)

Tensile strength R _m N/mm ²	Yielding strength R _{p0,2} N/mm ²	Elongation A ₅ %
750	500	17

Weld metal analysis

(typical, wt %)

C	Si	Mn	Cr	Ni	Nb
0,42	1,2	1,8	26,0	35,0	1,3

Gas types EN 439

S = solid wire

M12, M13

T = bare rod

I1

Current

Diameter mm
Welding amps (A) min.
(A) max.

= +				= -				
0,8	1,0	1,2	1,6	1,6	2,0	2,4	3,2	4,0
80	120	180	250					
130	190	250	320					

coils, weight

Rev. 001/13

B300 15 kg.

10 kg.