

CARBO 4332 AC

International standards	Material No.	1.4332
	EN 1600	E 23 12 L R 12
	AWS A 5.4	E309L-17

Approvals TÜV, UDT

Characteristics and typical applications CARBO 4332 AC is an AC-weldable, rutile-coated electrode with an alloyed core, suitable for joining difficult-to-weld steels and for corrosion-proof plating.
An austenitic 18/10 type CrNi weld metal can be obtained already in the first layer.
The 4332 alloy is also suitable for buffer layers on plated metal sheets.
The highly alloyed weld metal deposited by the CARBO 4332 AC electrode ensures crack-proof welds and is scale-resistant up to 1,000°C.

Operating temperature - 60° C up to +300° C

Base materials Combined compound of 1.4583 with HI / H II, 17 Mn 4, StE 355.
1.4583 with P235GH / P256GH, P295GH, P355N

1.4825 GX25CrNiSi18-9
1.4826 GX40CrNiSi22-9
1.4828 X15CrNiSi20-10
1.4832 GX25CrNiSi20-14

1.4301 X5CrNi18-10 for cladding

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 - 120° C
	590	> 400	> 32	> 32

Weld metal analysis % (typical)	C	Si	Mn	Cr	Ni
	< 0,04	0,9	0,7	24	13

Current = + / ~ , 42 V

Welding positions PA, PB, PC, PD, PE, PF

Rebaking 1 h, 350° C + / - 10° C (if necessary)

Dia./Length	Amperage (A)	Pcs./packet	Pcs./carton	kg/1000	kg/packet	kg/carton
2,0 x 300	30 - 60	342	1368	11,7	4,0	16,0
2,5 x 300	40 - 75	219	874	18,3	4,0	16,0
3,2 x 350	75 - 110	139	556	36,0	5,0	20,0
4,0 x 350	90 - 140	92	366	54,0	5,0	20,0
5,0 x 450	130 - 170	55	219	109,7	6,0	24,0