

CARBO 4430 FALL

International standards	Material No.	1.4430
	EN 1600	E 19 12 3 L R 11
	AWS A 5.4	E316L-17

Approvals ---

Typical applications and characteristics

CARBO 4430 FALL is a very thinly rutile-basic coated electrode with an alloyed core, suitable for joining corrosion-proof CrNiMo stainless steels with low-carbon content as well as stabilised and non-stabilised base materials of same or similar type which are subject to service temperatures from – 60° C up to 400° C, as used in the chemical and petrochemical industries, in refineries, etc.

The electrode is especially designed for welding in **VERTICAL DOWN POSITION (PG)**.

The alloy is non-scaling up to 875° C in air and oxidising gases atmosphere. No risk of intercrystalline corrosion due to the low C-content.

The weld metal is capable of taking a high polish.

Operating temperature - 60° C up to + 400° C

Base materials	1.4404 X2CrNiMo17-13-2	1.4437 GX6CrNiMo18-12
	1.4435 X2CrNiMo18-14-3	1.4408 GX5CrNiMo19-11-2
	1.4409 GX2CrNiMo19-11-2	1.4571 X6CrNiMoTi17-12-2
	1.4429 X2CrNiMoN17-13-3	1.4580 X6CrNiMoNb17-12-2
	1.4401 X5CrNiMo17-12-2	1.4581 GX5CrNiMoNb19-11-2
	1.4436 X3CrNiMo17-13-3	1.4583 (G)X10CrNiMoNb18-12

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 room temperature
550	360	39	75

Weld metal analysis
(typical, wt. %)

C	Si	Mn	Cr	Ni	Mo
< 0,03	0,7	0,7	19	12	2,8

Current = + / ~ / 50 V

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

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

Dia./Length	Amperage (A)	Pcs./packet	Pcs./carton	kg/1000	kg/packet	kg/carton
2,0 x 300	40 - 50	385	1538	10,4	4,0	16,0
2,5 x 300	50 - 70	247	988	16,2	4,0	16,0
3,2 x 350	70 - 90	156	625	32,0	5,0	20,0