

International standards	Material No.	1.4462
	EN 1600	E 22 9 3 N L R 12
	AWS A 5.4	E2209-17

Approvals TÜV, UDT

Typical applications and characteristics CARBO 4462 AC is an AC-weldable electrode with an alloyed core, suitable for welding on compound steels of same or similar type. The weld deposit is resistant to pitting, stress corrosion cracking and intercrystalline corrosion at temperatures up to 250° C. Furthermore, the weld metal alloy is saltwater-proof and performs high tensile strength, as a result of nitrogen being added to the alloy.

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	GX6CrNiMo24-8-2
	1.4417	GX2CrNiMoN25-7-3	1.4470	GX2CrNiMoN22-5-3
	1.4426	GX10CrNiMoN15-4-2	1.4575	X1CrNiMoNb28-4-2
	1.4460	X3CrNiMoN27-5-2	1.4582	X4CrNiMoNb25-7

Dissimilar 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 (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 - 40° C
	780	610	26	44

Weld metal analysis (typical, wt %)	C	Si	Mn	Cr	Ni	Mo	N
	< 0,03	0,9	0,7	22,5	9	3	0.1

Current = + / ~ / 50 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	345	1379	11,6	4,0	16,0
2,5 x 300	40 - 70	221	884	18,1	4,0	16,0
3,2 x 350	60 - 110	140	559	35,8	5,0	20,0
4,0 x 350	90 - 145	92	369	54,2	5,0	20,0
5,0 x 450	120 - 180	55	221	108,8	6,0	24,0