

CARBO 4462 Cu AC

International standards	Material No.	1.4462 similar
	EN 1600	E 25 9 3 Cu N L R 12
	DIN 8555	E9-UM-300-CKR

Approvals ---

Typical applications and characteristics CARBO 4462 Cu AC is an AC-weldable electrode with an alloyed core, suitable for corrosion resistant platings. 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. The deposits give better corrosion results than the Cu free version.

Operating temperature - 40° C up to + 250° C

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	Hardness HB
	850	700	30	>32	ca.300

Weld metal analysis (typical, wt %)	C	Si	Mn	Cr	Ni	Mo	N	Cu
	0,03	0,8	0,7	25	9	4	0,2	2,5

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
2,5 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