

CARBO 4316 B

International standards	Werkstoff Nr.	1.4316
	EN 1600	E 19 9 L B 22
	AWS A 5.4	E308L-15
	DIN 8556	E 19 9 L B 20+

Approvals ---

Characteristics and typical applications CARBO 4316 B is basic coated electrode with an alloyed core, suitable for joining corrosion-proof CrNi steels with low carbon content as well as stabilised and non-stabilised steels of identical or similar characteristics which are resistant to chemical agents. Used on a base metal of identical characteristics the weld metal is resistant to wet corrosion up to 350° C. CARBO 4316 B is scale resistant up to 875°C in an air and oxidising gases atmosphere. No intercrystalline corrosion due to low carbon content.

The weld metal is capable of taking high polish.

Operating temperature -60° C up to +350° C

Base materials	1.4301 X5CrNi18-10	1.4311 X2CrNiN18-10
	1.4303 X4CrNi18-12	1.4312 GX10CrNi18-10
	1.4306 X2CrNi19-11	1.4541 X6CrNiTi18-10
	1.4308 GX5CrNi19-10	1.4550 X6CrNiNb18-10
	1.4309 GX2CrNi19-11	1.4552 GX5CrNiNb19-11

Mechanical properties of all-weld metal	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
	(typical values)	560	380	> 35

Weld metal analysis % (typical)	C	Si	Mn	Cr	Ni
	< 0,03	0,8	0,7	19	10

Current = +

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 pcs.	kg/packet	kg/carton
2,0 x 300	40 - 60	417	1667	9,6	4,0	16,0
2,5 x 300	60 - 80	265	1060	15,1	4,0	16,0
3,2 x 350	75 - 105	168	673	29,7	5,0	20,0
4,0 x 350	100 - 140	111	444	45,0	5,0	20,0
5,0 x 450	130 - 170	66	266	90,3	6,0	24,0
6,0 x 450	150 - 200	46	184	130,1	6,0	24,0

Rev. 000