

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

Approvals TÜV,

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 steels. (DUPLEX SS 2205 (UNS S 32205) 1.4462)
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 A₅ %	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	3,3	0.12

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

Rev. 000

Statements on composition and application are just for the applier's information. Statements on mechanical properties always refer to the all-weld-metal according to valid standards. Carbo-Weld may change the characteristics of its products without notice. We recommend the applier to check our products for their special application autonomously.