

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

Approvals

Typical applications and characteristics

CARBO 4462 B is a basic coated 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 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	3,3	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.