

# CARBO 4519 AC

<b>International standards</b>	Material No.	1.4519
	EN 1600	E 20 25 5 Cu N L R 12
	AWS A 5.4	E385-17

**Approvals** ---

**Typical applications and characteristics** CARBO 4519 AC is an electrode with an alloyed core wire, well suited for joint welding on the same or similar corrosion resistant CrNiMoCu steels along with low alloyed steels. Overlays with this electrode leave a pierce and tension resistant deposit that is also resistant to intergranular (IK) corrosion, specifically from acids and non-oxidating materials (i.e. sulfuric, phosphorous acids or ammonium acetate).

**Operating temperature** - 60° C up to + 400° C

<b>Base materials</b>	1.4339 GX32CrNi28-10	1.4536 GX 2 NiCrMoCuN 20-18
	1.4500 GX7NiCrMoCuNb25-20	1.4539 X 1 NiCrMoCu25-20-5
	1.4505 X4NiCrMoCuNb20-18-2	1.4585 GX7CrNiMoCuNb18-18
	1.4506 X5NiCrMoCuTi20-18	1.4586 X5NiCrMoCuNb22-18
	1.4531 GX2NiCrMoCuN20-18	

<b>Mechanical properties of all-weld metal</b> ( typical values )	Tensile strength $R_m$ N/mm <sup>2</sup>	Yield strength $R_{p0,2}$ N/mm <sup>2</sup>	Elongation $A_5$ %	Impact strength ISO – V J at 20°C      - 40° C	
	580	380	40	130	80

<b>Weld metal analysis</b> (typical, wt %)	C	Si	Mn	Cr	Ni	Mo	Cu
	0,02	0,8	1	20	25	4,5	1,5

**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	60 - 80	222	889	18,0	4,0	16,0
3,2 x 350	80 – 110	141	563	35,5	5,0	20,0
4,0 x 350	115 - 140	93	372	53,7	5,0	20,0

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