

International standards	Material No.	1.4576
	EN 1600	E 19 12 3 Nb R 12
	AWS A 5.4	E318-17

Approvals TÜV, BB, CE

Typical applications and characteristics CARBO 4576 AC is an AC-weldable, rutile-coated electrode with an alloyed core, suitable for joining corrosion-proof CrNiMo-steels as well as stabilized and non-stabilized base materials of same or similar characteristics which are resistant to chemical agents. Combined with a base material of same characteristics the weld metal is resistant to wet corrosion up to 400°C. The weld metal alloy is scale-resistant up to 875°C in air and in oxidizing gases atmosphere.

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

Base materials	1.4401 X5CrNiMo17-12-2	1.4571 X6CrNiMoTi17-12-2
	1.4436 X3CrNiMo17-13-3	1.4579 X6CrNiMoTi17-12-2
	1.4437 GX6CrNiMo18-12	1.4580 X6CrNiMoNb17-12-2
	1.4408 GX5CrNiMo19-11-2	1.4583 (G)X10CrNiMoNb18-12

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 -60° C
	590	400	36	57

Weld metal analysis (typical, wt %)	C	Si	Mn	Cr	Ni	Mo	Nb
	< 0,07	0,8	0,6	19	11	2.6	≥ 8 x C %

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	35 - 55	345	1379	11,6	4,0	16,0
2,5 x 300	55 - 75	221	884	18,1	4,0	16,0
3,2 x 350	70 - 105	140	559	35,8	5,0	20,0
4,0 x 350	100 - 140	92	369	54,2	5,0	20,0
4,0 x 450	100 - 140	86	345	69,6	6,0	24,0
5,0 x 450	130 - 170	55	221	108,8	6,0	24,0

Rev. 000