

International standards	Material No.	1.4576
	EN 1600	E 19 12 3 Nb B 22
	AWS A 5.4	E318-15

Approvals ---

Typical applications and characteristics CARBO 4576 B is a basic-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

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 = +

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	392	1569	10,2	4,0	16,0
2,5 x 300	45 - 80	250	1000	16,0	4,0	16,0
3,2 x 350	60 - 105	159	635	31,5	5,0	20,0
4,0 x 350	100 - 140	105	418	47,8	5,0	20,0
5,0 x 450	120 - 170	63	250	96,0	6,0	24,0

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