

CARBO 4820 B

International standards	Material No.	1.4820
	EN 1600	E 25 4 B 22

Approvals --

Typical applications and characteristics CARBO 4820 B is an basic-coated fully core-wire alloyed electrode for fabrication-welding on equal or similar, corrosion and heat-resistant steels and steel-castings.
The weld-deposit is on equal base-material scale-resistant and, by reason of its low nickel-content, resistant against attack of sulphurous gases at higher temperatures up to 1150°C. When welding CARBO 4820 AC low heat-input should be guaranteed as alloys of such chemistry are sensitive to embrittlement at 600-800°C.
The interlayer-temperature must not exceed 300°C.

Operating temperature From room temperature up to + 1150° C

Base materials	1.4340 GX40CrNi27-4	1.4745 GX40CrSi23
	1.4710 GX30CrSi6	1.4746 X8CrTi25
	1.4711 X10CrSi6	1.4762 X10CrAl24
	1.4722 X10CrSi13	1.4776 GX40 CrSi29
	1.4723 X10 CrAl13	1.4821 X20CrNiSi25-4
	1.4740 GX40CrSi17	1.4822 GX40CrNi24-5
	1.4741 X2CrAlTi18-2	1.4823 GX40CrNiSi27-4
	1.4742 X10CrAl18	

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 %	hardness HB
	700	500	20	Ca. 180

Weld metal analysis (typical, wt %)	C	Si	Mn	Cr	Ni
	0,06	1,0	0,7	25	4,7

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
2,5 x 300	60 - 80	222	889	18,0	4,0	16,0
3,2 x 350	80 - 100	145	580	33,7	5,0	20,0
4,0 x 350	120 - 150	95	381	52,8	5,0	20,0

Rev. 000