

CARBO S-1.4459

CARBO T-1.4459

International standards

	S = massive wire	T = bare rod
M. Nr.	1.4459	
EN 12072	G 23 12 2 L	W 23 12 2 L
AWS A 5.9	ER309LMo	ER309LMo

Application notes

A continuous, solid, corrosion-resistant, chromium-nickel-molybdenum wire for the GMA welding of stainless steel. CARBO S-1.4459 has good resistance to general corrosion. The alloy is often used for joining stainless steels to non-alloy or low-alloy steels where corrosion resistance is of less importance. CARBO S-1.4459 is usually welded with Ar/(1-3%) O₂ as the shielding gas.

Base materials

1.4583 with H I / H II, 17 Mn 4, StE 355.
P235GH / P256GH, P295GH, P355N
1.4401 X 5 CrNiMo 17 12 3
1.4404 X 2 CrNiMo 17 13 2

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 at 20° C
550	320	35	70

Weld metal analysis (typical, wt. %)

C	Si	Mn	Cr	Ni	Mo
0,02	0,35	1,5	22	14	2,6

Gas types EN 439

S = massive wire

M13

T = bare rod

I1

Current

Diameter mm
Welding amps (A) min.
(A) max.

	= +				= -				
	0,8	1,0	1,2	1,6	1,6	2,0	2,4	3,2	4,0
(A) min.	80	120	180	250					
(A) max.	130	190	250	320					

coils, weight

Rev. 000

B300 15 kg.

10 kg.