

# CARBO S- 4853

# CARBO T- 4853

## International standards

	S = massive wire	T = bare rod
W. Nr.	1.4853	
EN 12072	G Z25 35	W Z25 35

## Approvals

## Application notes

Wire electrode suitable for fabrication welding and claddings on equivalent or similar corrosion and heat resistant steels and centrifugal castings.  
The deposits are applied on centrifugally cast tubes as well as on parts of reformer- and industrial furnaces where high heat and scale resistant under mechanical, thermal and corrosive load is essential.  
The scaling resistance is guaranteed up to 1050°C. Creep rupture reaches values up to 80% of the base material HP.  
Further the alloy has a good resistance to carburisation and sulphuric gases

**Operating temperature** Rt. up to 1050° C

**Structure** Austenite

**Base materials** 1.4852 GX40 NiCrSiNb35-25                      1.4857 GX40NiCrSi35-25

## Mechanical properties of all-weld-metal

(typical values)

Tensile strength R <sub>m</sub> N/mm <sup>2</sup>	Yielding strength R <sub>p0,2</sub> N/mm <sup>2</sup>	Elongation A <sub>5</sub> %
750	500	17

## Weld metal analysis

(typical, wt %)

C	Si	Mn	Cr	Ni	Nb
0,42	1,2	1,8	26,0	35,0	1,3

## Gas types EN 439

**S = massive wire**

M12, M13

**T = bare rod**

I1

## Current

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

## coils, weight

Rev. 000

B300 15 kg.

10 kg.