

# CARBO 4551 B

<b>International standards</b>	Material No.	1.4551
	EN ISO 3581-A	E 19 9 Nb B 22
	AWS A 5.4	E347-15

## Approvals

### Characteristics and typical applications

CARBO 4551 B is a basic electrode with an alloyed core, suitable for joining corrosion-proof stabilized or unstabilized CrNi steels of identical or similar characteristics which are resistant to chemical agents. Used on a base metal of identical characteristics the weld metal is resistant to wet corrosion up to 400° C. The deposit is scale resistant up to 875°C in an air and oxidising gases atmosphere.

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

<b>Base materials</b>	1.4300 X 12 CrNi 18 8	1.4541 X6CrNiTi18-10
	1.4301 X5CrNi18-10	1.4550 X6CrNiTi18-10
	.4308 GX5CrNi19-10	1.4552 GX5CrNiNb19-11
	.4312 GX10CrNi18-10	

### Mechanical properties of all-weld metal

(typical values)

Tensile strength $R_m$ N/mm <sup>2</sup>	Yield strength $R_{p0,2}$ N/mm <sup>2</sup>	Elongation $A_5$ %	Impact strength ISO-V J at - 120° C
600	400	40	53

### Weld metal analysis (typical, wt %)

C	Si	Mn	Cr	Ni	Nb
0,06	0,9	0,7	20	10	≥ 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 pcs.	kg/packet	kg/carton
2,0 x 300	25 - 55	417	1667	9,6	4,0	16,0
2,5 x 300	40 - 80	265	1060	15,1	4,0	16,0
3,2 x 350	65 - 110	168	673	29,7	5,0	20,0
4,0 x 350	100 - 140	111	444	45,0	5,0	20,0
5,0 x 450	120 - 170	66	266	90,3	6,0	24,0

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