

CARBO 4820 MPR

International standards		Material No.		1.4820					
		EN ISO	3581-A		E 25 4 R	52			
		DIN 855	6		E 25 4 M	P R 2	23		
Approvals									
Typical application and characteristics		CARBO 4820 MPR is an AC-weldable electrode with a recovery of 140% 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 tempera	ture	ture From room temperature up to + 1150° C							
Base materials		1.4340 GX40CrNi27-4 1.4710 GX30CrSi6 1.4711 X10CrSi6 1.4722 X10CrSi13 1.4723 X10 CrAl13 1.4740 GX40CrSi17 1.4741 X2CrAlTi18-2 1.4742 X10CrAl18				1.4745 GX40CrSi23 1.4746 X8CrTi25 1.4762 X10CrAl24 1.4776 GX40 CrSi29 1.4821 X20CrNiSi25-4 1.4822 GX40CrNi24-5 1.4823 GX40CrNiSi27-4			
			X10CrA	118					
Mechanical proper	ties				- 4	F 1-		la a suda a	
Mechanical proper of all-weld metal	ties	1.4742	sile	Yield	strength		ngation	hardne	
	ties	1.4742	sile th R _m	Yield	strength N/mm²		ngation A₅ %	hardne HB	
of all-weld metal	ties	1.4742 Tens streng	sile th R _m m²	Yield R _{p0,2}			-		•
of all-weld metal (typical values)		1.4742 Tens streng N/m 70	sile th R _m m ² 0	Yield R _{p0,2}	N/mm² 500		A ₅ %	HB	•
of all-weld metal (typical values) Weld metal analys		1.4742 Tens streng N/m 70	sile th R _m Im ² 0 Si	Yield R _{p0,2}	N/mm² 500	Ni	A ₅ %	HB	•
of all-weld metal (typical values)		1.4742 Tens streng N/m 70	sile th R _m m ² 0	Yield R _{p0,2}	N/mm² 500		A ₅ %	HB	•
of all-weld metal (typical values) Weld metal analys		1.4742 Tens streng N/m 70	sile th R _m m ² 0 Si 1,0	Yield R _{p0,2}	N/mm² 500	Ni	A ₅ %	HB	•
of all-weld metal (typical values) Weld metal analys (typical, wt %)		1.4742 Tens streng N/m 70 C 0,06	sile th R _m m ² 0 50 V	Yield R _{p0,2} 	N/mm² 500 Cr 25	Ni	A ₅ %	HB	•
of all-weld metal (typical values) Weld metal analys (typical, wt %) Current		1.4742 Tens streng N/m 70 C 0,06 = + / ~ / 2 PA, PB,	sile th R _m m ² 0 Si 1,0 50 V PC, PD,	Yield R _{p0,2} Mn 0,7 PE, PF	N/mm² 500 Cr 25	Ni 4,7	A ₅ %	HB	•
of all-weld metal (typical values) Weld metal analys (typical, wt %) Current Welding positions	is	1.4742 Tens streng N/m 70 C 0,06 = + / ~ / 2 PA, PB,	sile th R _m 0 <u>Si</u> 1,0 50 V PC, PD, ° C + / -	Yield R _{p0,2} Mn 0,7 PE, PF	N/mm ² 500 Cr 25	Ni 4,7	A ₅ %	HB	•
of all-weld metal (typical values) Weld metal analys (typical, wt %) Current Welding positions Rebaking	is Ampe	1.4742 Tens streng N/m 70 C 0,06 = + / ~ / * PA, PB, 1 h, 350°	sile th R _m 0 <u>Si</u> 1,0 50 V PC, PD, ² C + / - Pcs./p	Yield R _{p0,2} Mn 0,7 PE, PF 10° C (N/mm² 500 Cr 25	Ni 4,7	A ₅ % 20	HB Ca. 18	80
of all-weld metal (typical values) Weld metal analys (typical, wt %) Current Welding positions Rebaking Dia./Length	is Ampe 7(1.4742 Tens streng N/m 70 C 0,06 = + / ~ / 2 PA, PB, 1 h, 350 erage (A)	sile th R _m m ² 0 Si 1,0 50 V PC, PD, ² C + / - Pcs./p 17	Yield R _{p0,2} Mn 0,7 PE, PF 10° C (backet	N/mm² 500 25 if necessa Pcs./car	Ni 4,7	A₅ % 20	HB Ca. 18	80 kg/carton

5,0 x 450 Rev. 001/12

4,0 x 450

Statements on composition and application are just for the applier's information. Statements on mechanical properties always refer to the all-weld-metal according to valid standards. Carbo-Weld may change the characteristics of its products without notice. We recommend the applier to check our products for their special application autonomously.

259

166

92,6

144,7

6,0

6,0

24,0

24,0

65

41

120 - 170

170 - 240