

CARBO 4850 B

International standards

Material No.	1.4850	
EN ISO 3581-A	E 22 33 Nb B 22	

Approvals

Typical applications and characteristics

CARBO 4850 B is a lime basic coated electrode with an alloyed core, suitable for joint welding on equivalent or similar corrosion and heat resis-

tant steels and cast steels.

The deposits are scale resistant up to 1050°C and have good resistance to carburising atmospheres, hot air, oxidising combustion gases or reduc-

ing combustion gases

Operating temperature Rt.

Rt. up to 1050° C

Structure Austenite

Base materials 1.4845 X12CrNi25-21 1.4865 GX40NiCrSi38-18

1.4849 GX40NiCrSiNb38-18 1.4876 X10NiCrAlTi32-20 (Alloy 800)

1.4859 GX10NiCrNb32-20 1.4861 X10NiCr32-20 1.4958 X5NiCrAlTi31-20 1.4864 X12NiCrSi36-16

1.4959 X8NiCrAlTi32-21 (Alloy 800 H)

Mechanical properties of all-weld metal (typical values)

Tensile strength R _m N/mm²	Yield strength R _{p0,2} N/mm ²	Elongation A₅ %	Impact strength ISO – V J at room temperature
600	380	25	45

Weld metal analysis (typical, wt %)

 C
 Si
 Mn
 Cr
 Ni
 Nb

 0,15
 0,6
 3,5
 21
 33
 1,5

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	50 - 70	225	899	17,8	4,0	16,0
3,2 x 350	60 - 110	143	571	35,0	5,0	20,0
4,0 x 350	90 - 140	94	377	53,1	5,0	20,0

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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.