

Standards

Material No.	1.4337
EN 1600	E 29 9
AWS A 5.4	E 312
DIN 8555	MF9-GF-200-CKRTZ

Characteristics and typical applications

CARBO F-4337, also known as the 29/9 alloy, is a cored wire which is excellent when welding dissimilar and unknown steels. It deposits austenitic ferritic weld metal and is recommended for use on higher carbon steels and where the base metal is unknown. The deposit is crack free, acid resistant and scale resistant to 1000°

Typical applications

Bridge bearings, sealing surfaces, corrosion slide ring sealing, roller bearings, valves, continuous cast rolls

Working temperature 20°C up to 300° C

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 20°C	Hardness HB
800	580	20	40	ca. 200

Weld metal analysis (typical, wt %)

C	Si	Mn	Cr	Ni
0,10	1	0,7	29	9

Gas types EN 439

I1, M13: Argon and 99% Argon with 1% Oxygen

Current

= +

Current intensity

DIA (mm)	DIA (inch)	Volt	Amps	Delivering form		
1,2	3/64					
1,6	1/16	20 - 26	160 - 260	O	G	
2,0	5/64	22 - 27	220 - 280	O	G	
2,4	3/32	24 - 28	260 - 340	O	G	S
2,8	7/64	25 - 29	300 - 400	O		S
3,2	1 / 8	26 - 30	320 - 460			S

Delivering form

O = Flux cored wire self shielding
G = Flux cored wire for shielded arc welding
S = Flux cored wire for submerged arc welding

Coils, weight

B/BS 300 = 15 kg B 450 = 30 kg pay off pack = 150 / 300 kg

Rev. 000