CARBO S- 4829
CARBO T- 4829

International standards

	S = solid wire	T = bare rod
Mat. No.	1.4829	
EN 12072	G 22 11	W 22 12

Approvals

Application notes

Suitable for welding corrosion and heat-resistant Cr/Ni steel and Cr/Ni steel to unalloyed and low alloy steels. Heat-resistant up to approximately 1050° C.

Operating temperature

Rt. up to 1050° C

Structure

Austenite

Base materials

1.4710
1.4713
1.4729
1.4740
1.4828
1.4878
1.4825

Mechanical properties of all-weld-metal

(typical values)

Tensile strength R_m N/mm²	Yielding strength $R_{p0,2}$ N/mm²	Elongation A_5 %
700	380	30

Weld metal analysis
(typical, wt %)

C	Si	Mn	Cr	Ni
0,10	0,8	1,8	22,0	11,0

		S = solid wire				T = bare rod				
Gas types EN 439		M13				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 B300 15 kg. 10 kg.

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