

# CARBO 4842 B

International standards	Material No.	1.4842
	EN 1600	E 25 20 B 22
	AWS A 5.4	E310-15

**Approvals** --

## Typical applications and characteristics

CARBO 4842 B is an basic-coated electrode with an alloyed core, suitable for joining corrosion-proof, highly heat-proof and non-scaling CrNi-steels which are subject to service temperatures up to 1200° C.  
The electrode is also suitable for joint welding Cr-, CrSi-, and CrAl steels and for cladding low alloy base metals. The weld metal alloy is highly hot-crack-proof.  
Keep temperature as low as possible during welding.  
Annealing to 250°C and post-weld tempering to 700°C is required on ferritic base materials.  
The electrode is mainly used in furnace-construction, for fittings and pipe-lines.

## 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 room temperature
600	350	30	90

## Weld metal analysis (typical, wt %)

C	Si	Mn	Cr	Ni
0,10	0,6	3	25	21

**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 - 75	267	1067	15,0	4,0	16,0
3,2 x 350	75 - 110	169	676	29,6	5,0	20,0
4,0 x 350	100 - 145	112	446	44,8	5,0	20,0
5,0 x 450	120 - 165	67	267	90,0	6,0	24,0

Rev. 000