CARBO 4853 B

International standards

Material No.	1.4853
EN 1600	E 25 35 Nb B 22

Approvals --

Typical applications and characteristics

CARBO 4853 B is a lime basic coated electrode with an alloyed core, suitable for fabrication welding and claddings on equivalent or similar corrosion and heat resistant steels and centrifugal castings.
The deposits are applied on centrifugally cast tubes as well as on parts of reformer- and industrial furnaces where high heat and scale resistant under mechanical, thermal and corrosive load is essential.
The scaling resistance is guaranteed up to 1050°C. Creep rupture reaches values up to 80% of the base material HP.
Further the alloy has a good resistance to carburisation and sulphuric gases

Operating temperature Rt. up to 1050° C

Structure Austenite

Base materials 1.4852 GX40 NiCrSiNb35-25 1.4857 GX40NiCrSi35-25

Mechanical properties of all-weld metal (typical values)

Tensile strength R_m N/mm²	Yield strength $R_{p0,2}$ N/mm²	Elongation A_5 %
750	500	17

Weld metal analysis (typical, wt %)

C	Si	Mn	P	S	Cr	Ni	Nb
0,4	1,0	2	0,02	0,006	24,5	35	1,3

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	231	925	17,3	4,0	16,0
3,2 x 350	70 - 100	147	588	34,0	5,0	20,0
4,0 x 350	80 - 120	97	388	51,5	5,0	20,0