CARBO 4948 B

International standards

Material No.	1.4948
EN 1600	E 19 9 B 22
AWS A 5.4	E308H-15

Approvals --

Typical applications and characteristics

CARBO 4948 B is a basic-coated electrode with an alloyed core, suitable for fabrication of austenic CrNi steels and steel castings.
The weld deposit shows excellent creep rupture characteristics.
The alloy is also suitable for welding austeniti CrNi steels with carbon contents higher than 0,4 % as well as for ACI conform castings.
The alloy is high temperature resistant up to 700 °C and schale resistant up to 800°C.

Operating temperature From room temperature up to + 700° C

Structure Austenit with 5% ferrit

Base materials

1.4301	X5CrNi18-10	1.4878	X 12CrNiTi19-9
1.4541	X6CrNiTi18-10	1.4948	X6CrNi18-11
1.4550	X6CrNiTi18-10	1.4949	X5CrNiN18-11

ACI Base Materials:
CF 3 (CPF 3) / CF 8 (CPF 8) / CF 8 C (CPF 8 C)

Mechanical properties of all-weld metal (typical values)

Tensile strength R_m N/mm²	Yield strength $R_{p0,2}$ N/mm²	Elongation A_5 %	Impact strength ISO – V J at room temperature
500	320	35	70

Weld metal analysis (typical, wt %)

C	Si	Mn	Cr	Ni
0,05	0,5	1,5	18,5	9,5

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
2,0 x 300	50 - 70	408	1633	9,8	4,0	16,0
2,5 x 300	60 - 90	260	1039	15,4	4,0	16,0
3,2 x 350	80 - 120	165	660	30,3	5,0	20,0
4,0 x 350	110 - 160	109	436	45,9	5,0	20,0
5,0 x 450	150 - 200	65	261	92,1	6,0	24,0