

Jungo® 4500

TOP FEATURES

- A rutile-basic fully austenitic all position electrode
- Smooth bead appearance, Easy slag release
- Designed for welding alloy 904L
- World wide reputation for reliability
- Weldable on DC+ polarity

TYPICAL APPLICATIONS

- Applications in phosphoric and sulphuric acids
- Paper mill equipment

CLASSIFICATION

AWS A5.4 E385-16*
EN ISO 3581-A E 20 25 5 Cu N L R 12

*Nearest classification

CURRENT TYPE

DC+

WELDING POSITIONS

All position, except vertical down

APPROVALS

TÜV

+

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Mn	Si	Cr	Ni	Mo	Cu	FN (acc. WRC 1992)
0.02	1.2	0.9	20.0	25.0	5.0	1.5	

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	0.2% Proof strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)		
					+20°C	-40°C	-60°C
Required: AWS A5.4		not specified	min. 520	min. 30	not specified		
EN ISO 3581-A		320	min. 510	min. 25	not specified		
Typical values	AW	410	620	40	100	50	50

AW = As welded

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 350	40 - 75
3.2 x 350	60 - 105

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 350	CBOH	105	2.2	561609-1
3.2 x 350	CBOX	164	5.0	561715-1

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.