

JUNGO 4500

MMA (SMAW)

PRODUCT DESCRIPTION

A rutile-basic fully austenitic all position electrode
 Smooth bead appearance
 Easy slag release
 Especially developed for applications in phosphoric acid and sulphuric acid and paper mill equipment
 Designed for welding alloy 904L
 World wide reputation for reliability
 Weldable on DC+ polarity

CLASSIFICATIONS

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

ASME IX QUALIFICATION

QW432 F-No 5
 QW442 A-No 9
 Mat-Nr 1.4519

WELDING POSITIONS (ISO/ASME)



PA/1G



PB/2F



PC/2G



PF/3Gu



PE/4G



PH/5Gu

CURRENT TYPE

DC+

TEMPERATURE RANGE

Pressurized parts -60...+400°C
 Oxidation resistance n.a

CHEMICAL COMPOSITION (WELD METAL WT %)

	C	Mn	Si	Cr	Ni	Mo	Cu	FN
Min.	--	1.0	--	19.0	24.0	4.0	1.0	--
Max.	0.04	4.0	1.2	22.0	27.0	7.0	2.0	--
Typical	0.02	1.2	0.9	20.0	25.0	5.0	1.5	0

ALL-WELD MECHANICAL PROPERTIES

As welded	AWS A5.4	ISO 3581-A	Typical
Tensile strength [MPa]	min. 520	min. 510	620
0.2% proof strength [MPa]	--	320	410
Elongation [%]	30	25	40
Impact ISO-V[J]	+20°C	--	100
	-40°C	--	80
	-60°C	--	50

TYPICAL OPERATING PARAMETERS

Diameter [mm]	2.5	3.2	4.0
min. A	40	60	80
max. A	75	105	145

PACKAGING DATA

	Diameter [mm]	Length [mm]	Item number	Nb of pieces		Weight (kg)	
				pack	carton	pack	carton
CARDBOARD BOX	2.5	350	561609	145	725	2.9	14.5
	3.2	350	561715	185	555	5.7	17.1
	4.0	350	561821	125	375	5.9	17.7

All information in this data sheet is accurate to the best of our knowledge at the time of printing. Please refer to www.specialalloys.eu for any updated information.