




CEWELD 4842 Kb

TYPE	Basic coated electrode for heat resistant stainless steels.(Type25 20, 310)																
APPLICATIONS	CEWELD® 4842 Kb is for the dissimilar welding of heat-resistant rolled, forged and cast steels. Common applications include industrial furnaces, annealing chambers, systems for treating molten salts and boiler parts as well as heat exchangers.																
PROPERTIES	CEWELD® 4842 Kb has good general oxidation resistance due to its high Cr content, especially at high temperatures. The alloy is fully austenitic and therefore sensitive to hot cracking in the 650-900°C temperature range. The temperature limits for use under intermittent oxidation depend on the frequency of cycling. In general, the alloy is resistant to scaling up to 1200°C. This alloy can withstand relatively strong thermal shocks and is therefore superior to type 309 L. Cold toughness down to - 196°C.																
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.4: E 310-15</td> </tr> <tr> <td>EN ISO</td> <td>3581-A: E 25 20 B 12</td> </tr> <tr> <td>W.Nr.</td> <td>~1.4842</td> </tr> <tr> <td>F-nr</td> <td>5</td> </tr> <tr> <td>FM</td> <td>5</td> </tr> </table>	AWS	A 5.4: E 310-15	EN ISO	3581-A: E 25 20 B 12	W.Nr.	~1.4842	F-nr	5	FM	5						
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SUITABLE FOR	1.4823, 1.4826, 1.4828, 1.4832, 1.4840, 1.4841, 1.4846, 1.4848, 1.4837, 1.4710, 1.4713, 1.4724, 1.4726, 1.4742, 1.4745, 1.4762, 1.4845, 1.4740 X15CrNiSi25-21, X8CrNi25-21, X15CrNiSi20-12, GX15CrNi25-20, X40CrNi25-21, GX40CrNiSi22-10, X10CrAlSi7, X10CrAlSi13, X10CrAlSi18, X10CrAlSi25, GX30CrSi7, GX40CrSi17 AISI 305, 310, 314, ASTM A297 HF, A297 HJ																
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TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1" style="width: 100%; text-align: center;"> <tr> <td>C</td> <td>Si</td> <td>Mn</td> <td>P</td> <td>S</td> <td>Cr</td> <td>Ni</td> </tr> <tr> <td>0.1</td> <td>0.5</td> <td>2</td> <td>0.02</td> <td>0.015</td> <td>26</td> <td>21</td> </tr> </table>	C	Si	Mn	P	S	Cr	Ni	0.1	0.5	2	0.02	0.015	26	21		
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Heat Treatment	R _{P0,2} (MPa)					R _m (MPa)	A ₅ (%)		Impact Energy (J) ISO-V		Hardness						
		RT	-196°C														
As Welded	380	570	30	75	37	HRc											
REDRYING	300°C / 2 hr																
GAS ACC. EN ISO 14175																	



CEWELD 4842 Kb

4842 KB 2,5 X 300MM

Packaging	KG/unit	EanCode
Can	2,5	8720663415776