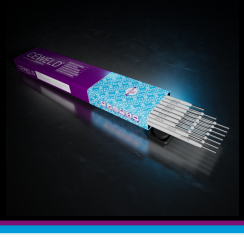


CEWELD 4820 AC

certilas® THE FILLER METAL SPECIALIST

TYPE

High Chromium electrode for high temperature applications.

APPLICATIONS

CEWELD® 4820 AC is a cored wire alloyed, AC weldable stick electrode (Preferred =+) for production and repair welding on similar or similar, corrosion and heat resistant steels and steel castings. For furnaces requiring improved resistance to reducing and oxidizing sulfurous gases as well as for fi nal passes of weld joints. Scaling resistant up to 1100ºC.

PROPERTIES

CEWELD® 4820 AC is scale-resistant on the same base material and, due to its low nickel content, is resistant to attack by sulphur gases and oxidizing combustion gases up to 1100ºC. When welding CEWELD® 4820 AC, a low heat input is required, as alloys of this chemistry tend to become brittle at 600-800°C. The preheating temperature for similar and dissimilar steels should be 100 - 200ºC, depending on composition and material thickness. The interpass temperature should not exceed 300°C.

CLASSIFICATION

EN ISO	3581-A: E 25 4 R 32
W.Nr.	1.4820
FM	5

SUITABLE FOR

Mo-free 25Cr(Ni) alloys
1.4340, 1.4710, 1.4745, 1.4746, 1.4712, 1.4762, 1.4713, 1.4773, 1.4722, 1.4776, 1.4724, 1.4820, 1.4729, 1.4821, 1.4740, 1.4822, 1.4742, 1.4823
GX40CrNi27-4, G-X30CrSi6, G-X40CrSi23, X10CrSi6 502, X10CrAl24, X10CrAl7, X8Cr30, X10CrSi13, G-X40CrSi29, X8CrTi25, X10CrAl13, G-X12 CrSi 26 5, G-X40CrSi13, X20 CrNiSi 25 4, G-X40CrSi17, G-X40CrNi 25 4, X10CrAl18, G-X40CrNiSi 27 4,
AISI 327, 442, 446, ASTM A 297 HC
UNS S44200, 44600, J92605, J93005, J92605

APPROVALS

CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S	Cr	Ni
0.1	1	2	0.02	0.01	26	5

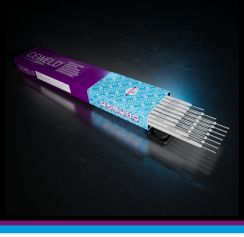
MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Hardness
As Welded	500	700	20	180 HB

REDRYING

300°C / 2 hr

GAS ACC. EN ISO 14175



CEWELD 4820 AC

certilas® THE FILLER METAL SPECIALIST

4820 AC 2,5 X 350MM

Packaging	KG/unit	EanCode
Can	2,5	8720663415660

4820 AC 3,2 X 350MM

Packaging	KG/unit	EanCode
Can	2,5	8720663415653