

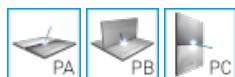


# CEWELD 4115 HLS

<b>TYPE</b>	High recovery, corrosion resistant stainless steel stick electrode										
<b>APPLICATIONS</b>	Hardfacing shafts from stainless steel parts, molt repairs, rebuilding pump parts etc. Suitable for plating and joining equal and similar ferritic Cr-steels and cast steels. Proper weldings are subject to the recommended heat treatment. This alloy is specially suitable for sealing surfaces on water-, steam and gas-valves, especially for sulphuric gases. The deposit is resistant to seawater, thin acids and scale resistant in air and oxidizing gases up to 950°C . The weld deposit can be tempered.										
<b>PROPERTIES</b>	High deposition rate and excellent weldability on DC +. Stainless steel alloy for joining and cladding 17% Chromium alloys and cladding components where heat and corrosion resistance simmlar to AISI 304 is required. The weld deposit can sustain working temperatures up to 450° C. and will offer a high hardness and wear resistance.										
<b>CLASSIFICATION</b>	<table border="0"> <tr> <td>AWS</td> <td>A 5.4: ~E 430HMo-26</td> </tr> <tr> <td>EN ISO</td> <td>3581-A: ~E Z 17 1 B 42</td> </tr> <tr> <td>W.Nr.</td> <td>1.4115</td> </tr> <tr> <td>F-nr</td> <td>1</td> </tr> <tr> <td>FM</td> <td>5</td> </tr> </table>	AWS	A 5.4: ~E 430HMo-26	EN ISO	3581-A: ~E Z 17 1 B 42	W.Nr.	1.4115	F-nr	1	FM	5
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<b>SUITABLE FOR</b>	1.4122 (G)X35CrMo17, 1.4313, 1.4000, 1.4001, 1.4002, Cast steels										

**APPROVALS**

**WELDING POSITIONS**



**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

C	Si	Mn	Cr	Mo
0.18	0.4	0.7	16.6	1

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Hardness
As Welded	>300	>450	>15	43 HRc
720°C±15°C 2h	>300	>450	>15	200 HB

**REDRYING** 300°C / 2 hr

**GAS ACC.** EN ISO 14175