CEWELD®

4820 AC

CATEGORY

SMAW Stick Electrodes

TYPE

High Chromium electrode for high temperature applications.

APPLICATIONS

Cap layers for joining refractory Cr-Al-Si steels. Cladding corrosion resistant overlays. Cladding heat resistant overlays up to 1150ºC. Cladding components in a sulphurous environment..

PROPERTIES

Ceweld 4820 AC is an AC-weldable fully core-wire alloyed electrode for fabrication and repair welding on equal or similar, corrosion and heat-resistant steels and steel-castings. The weld-deposit is on equal base-material scale-resistant and, by reason of its low nickel-content, resistant against attack of sulphurous gases at higher temperatures up to 1150°C. When welding Ceweld 4820 AC low heat-input is required as alloys of such chemistry are sensitive to embrittlement at 600-800°C. The interpas temperature should not exceed 300°C.

CLASSIFICATION

AWS	A 5.4: ~E 2504-17
EN ISO	3581-A: E 25 5 R 32
DIN: W.Nr.	1.4820
DIN	8556: E 25 4 MP R 23

SUITABLE FOR

W.Nr:	EN ASTM/ACI	W.Nr:	EN ASTM/ACI
1.4710	G-X30CrSi6	1.4724	X10CrAl13 TP405-CA15
1.4745	G-X40CrSi23 TP433	1.4820	G-X12 CrSi 26 5
1.4712	X10CrSi6 502	1.4729	G-X40CrSi13
1.4762	X10CrAl24 TP443	1.4821	X20 CrNiSi 25 4 TP329
1.4713	X10CrAl7 502	1.4740	G-X40CrSi17
1.4773	X8Cr30	1.4822	G-X40CrNi 25 4 TP329
1.4722	X10CrSi13	1.4742	X10CrAl18 430B-TP430
1.4776	G-X40CrSi29	1.4823	G-X40CrNiSi 27 4 TP329HC

WELDING POSITIONS:

WELD DEPOSIT WEIGHT %

C	Mn	Si	Cr	Ni	Mo
0.06	0.7	1.0	25	4.7	-

TYPICAL MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (N/mm^2)	Rm (N/mm^2)	A5 (%)	Impact Energy (J) ISO-V -20°C	-40°C	-60°C	Hardness HB
AW	500	700	20				180

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Length (mm)	Current (A) DC+/AC	kg / can	kg / 6pack	kg / pallet
2.5	300	60-80	2.5	15	750
3.2	350	80-120	2.8	16.8	840
4.0	350	120-150	2.8	16.8	840

REDRYING TEMPERATURE

1 hr/ 350° C +/- 10°C (if necessary)