



CEWELD 4829 MoTi

TYPE Austenitic rutile stick electrode for welding Cr-Ni-Mo steels. (Type E 23 12 2 L R / E309LMo)

APPLICATIONS CEWELD® 4829 MoTi is for joining heat resistant CrNi-steels of the same kind and also joining dissimilar alloys such as steel to stainless steel. Cladding on low alloyed steels in case a 18/8/2 CrNiMo layer is required in the first layer.

PROPERTIES The increased ferrite content (FN~19) in the weld metal of CEWELD® 4829 MoTi enables high crack resistance with materials that are less suitable for welding. Particularly easy processing with very good seam appearance, both with direct and alternating current. Self-lifting slag. For application temperatures from -60°C to 300°C, for 1st layer weld claddings up to 400°C.

CLASSIFICATION

AWS	A 5.4: E 309LMo-16
EN ISO	3581-A: E 23 12 2 L R 32
W.Nr.	1.4459
F-nr	1
FM	5

SUITABLE FOR **23% Cr, 12%Ni, 3% Mo, 309LMo**
 1.4401, 1.4404, 1.4406, 1.4410, 1.4437, 1.4571, 1.4580, 1.4459, 1.4513, 1.4521, 1.4526, 1.4113, 1.4575
 AISI 436, 444, 434
 UNS S43600, S 44400, S43400,

APPROVALS CE

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S	Cr	Ni	Mo
0.02	0.7	1.8	0.02	0.015	24	13	2.5

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
				RT		
As Welded	460	650	32	55		HRc

REDRYING 300°C / 2 hr

GAS ACC. EN ISO 14175



CEWELD 4829 MoTi

4829 MOTI 2,0 X 300MM

Packaging	KG/unit	EanCode
Can	2,4	8720663415707

4829 MOTI 2,5 X 300MM

Packaging	KG/unit	EanCode
Can	2,5	8720663415714

4829 MOTI 3,2 X 350MM

Packaging	KG/unit	EanCode
Can	2,8	8720663415721

4829 MOTI 4,0 X 350MM

Packaging	KG/unit	EanCode
Can	2,8	8720663415738

4829 MOTI 5,0 X 450MM

Packaging	KG/unit	EanCode
Can	3,0	8720663415745