



CEWELD 4820 AC

TYPE High Chromium electrode for high temperature applications.

APPLICATIONS CEWELD® 4820 AC is a high-alloy rod electrode with an alloyed core rod (preferably =+), which can be welded with alternating current and is suitable for production and repair welding work on similar or similar corrosion- and heat-resistant steels and steel castings. For furnaces that require improved resistance to reducing and oxidizing sulfur-containing gases, as well as for the final welding of welded joints. Resistant to spalling up to 1100 °C.

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 1100°C. 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 - 200°C, 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**
1.4710, 1.4712, 1.4713, 1.4722, 1.4724, 1.4729, 1.4740, 1.4742, 1.4745, 1.4762, 1.4773, 1.4776, 1.4820, 1.4821, 1.4822, 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)	R _m (MPa)	A ₅ (%)	Hardness
As Welded	500	700	20	180 HB

REDRYING 300°C / 2 hr

GAS ACC. EN ISO 14175



CEWELD 4820 AC

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