



# CEWELD 4462 Kb

|                                             |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                           |                      |                    |                         |       |     |          |      |
|---------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------|----------------------|--------------------|-------------------------|-------|-----|----------|------|
| TYPE                                        | High basic electrode for welding duplex stainless steels                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                           |                      |                    |                         |       |     |          |      |
| APPLICATIONS                                | Used for pipe work and general fabrication in the offshore oil and gas and chemical process industries. Also suitable for cladding steels to obtain corrosion resistant layers..                                                                                                                                                                                                                                                                                                                                                          |                           |                      |                    |                         |       |     |          |      |
| PROPERTIES                                  | A high basic electrode for welding austenitic-ferritic stainless alloys of the 22% Cr, 5% Ni, 3% Mo types. CEWELD® 4462 Kb has high general corrosion resistance. In media containing chloride and hydrogen sulphide, the alloy has a high resistance to intergranular corrosion, pitting and especially to stress corrosion. The alloy is used in a variety of applications across all industrial segments.                                                                                                                              |                           |                      |                    |                         |       |     |          |      |
| CLASSIFICATION                              | AWS                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | A 5.4: E 2209-15          |                      |                    |                         |       |     |          |      |
|                                             | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | 3581-A: E 22 9 3 N L B 22 |                      |                    |                         |       |     |          |      |
|                                             | W.Nr.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | 1.4462                    |                      |                    |                         |       |     |          |      |
|                                             | F-nr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | 5                         |                      |                    |                         |       |     |          |      |
|                                             | FM                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | 5                         |                      |                    |                         |       |     |          |      |
| SUITABLE FOR                                | ISO 15608: 10.1-10.2 Austenitic > 24 % Cr ≤ 4% Ni, DUPLEX 2209, 22%Cr 9%Ni 3%Mo<br>1.4417, 1.4462, 1.4362, 1.4162, 1.4463, 1.4460, 1.4583<br>X 2 CrNiMoSi 19 5, X 2 CrNiN 23 4, X 2 CrNiMoN 22 5 3, X10CrNiMoNb18-12<br>316LN, 318LN<br>UNS S31803, S32205, S32304<br>SAF 2205 Fafer 4462, NKCr22, SM22Cr, Falc 223 UR 45N & UR 45N+, 2101, 2205, UR 35 N SAF 2304<br>mix 1.4462 X2CrNiMoN22-5-3 mit P235GH/ P265GH, S255N, P295GH, S355N, 16Mo3                                                                                          |                           |                      |                    |                         |       |     |          |      |
| APPROVALS                                   | CE                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                           |                      |                    |                         |       |     |          |      |
| WELDING POSITIONS                           | <div>PAPBPCPDPEPF</div> |                           |                      |                    |                         |       |     |          |      |
| TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%) | C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | Si                        | Mn                   | P                  | S                       | Cr    | Ni  | Mo       | N    |
|                                             | 0.02                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | 0.8                       | 1.1                  | 0.02               | 0.015                   | 22.5  | 9.5 | 3.5      | 0.18 |
| MECHANICAL PROPERTIES                       | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | R <sub>p0,2</sub> (MPa)   | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Impact Energy (J) ISO-V |       |     | Hardness |      |
|                                             |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                           |                      |                    | RT                      | -50°C |     |          |      |
|                                             | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | 620                       | 750                  | 25                 | 95                      | 70    |     |          | HRc  |
| REDRYING                                    | 300°C / 2 hr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                           |                      |                    |                         |       |     |          |      |
| GAS ACC. EN ISO 14175                       |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                           |                      |                    |                         |       |     |          |      |



# CEWELD 4462 Kb

4462 KB 2,5 X 300MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Can       | 2,5     | 8720663424358 |

4462 KB 3,2 X 350MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Can       | 2,8     | 8720663413147 |