CEWELD AA 4820

certilas® THE FILLER METAL SPECIALIST

TYPE

High-alloyed tubular wire based on a 25% Chromium and 4% Nickel deposit for cladding and joining components against corrosion, high-heat and wear resistance. Developed for gas shielded arc welding.

APPLICATIONS

- Cap layers for joining refractory Cr-Al-Si steels. - Cladding corrosion resistant overlays. - Cladding heat resistant overlays up to 1100°C. - Cladding components in a sulphurous environment.

PROPRIÉTÉS

Higher productivity, higher deposition rates and improved wetting properties compared to solid wires with comparable analysis. Excellent weld metal quality and X-ray soundness.

CLASSIFICATION

EN ISO	17633-A: TZ 25 4 M M21 1
W.Nr.	1.4820
FM	5

CONVIENT POUR

1.4340, 1.4710, 1.4745, 1.4746, 1.4712, 1.4762, 1.4713, 1.4773, 1.4722, 1.4776, 1.4724, 1.4820, 1.4729, 1.4821, 1.4740, 1.4822, 1.4742, 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

AGRÉMENTS

POSITIONS DE SOUDAGE

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Cr	Ni	Mo
0.08	1	0.7	25	4.6	0.25

PROPRIÉTÉS MÉCANIQUES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Hardness
As Welded	>450	>650	>15	94 HB

ETUVAGE

Not required

GAS ACC. EN ISO 14175

M21

CEWELD AA 4820

AA 4820 1,6MM

Packaging	KG/unit	EanCode
BS-300	15	8720663415875
Drum	250	8720663415882