



CEWELD AA 4820

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.

ANWENDUNGEN - 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.

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

KLASSIFIKATION

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

GEEIGNET FÜR 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**
 G-X30CrSi6, G-X40CrSi23 TP433, X10CrSi6 502, X10CrAl24 TP443, X10CrAl7 502, X8Cr30, X10CrSi13, G-X40CrSi29, X10CrAl13 TP405-CA15, G-X12CrSi 26 5, G-X40CrSi13, X20CrNiSi 25 4 TP329, G-X40CrSi17, G-X40CrNi 25 4 TP329, X10CrAl18 430B-TP430, G-X40CrNiSi 27 4 TP329HC
 AISI 327, ASTM A297HC

ZULASSUNGEN

SCHWEISSPOSITIONEN



TYPISCHE CHEMISCHE ANALYSE DES SCHWEISSMETALLS (%)

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

MECHANISCHE GÜTEWERTE

Heat Treatment	R _{p0.2} (MPa)	R _m (MPa)	A5 (%)	Hardness
As Welded	>450	>650	>15	94 HB

RÜCKTROCKNUNG 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