



# CEWELD AA 4820

|                                             |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                          |                      |                    |          |      |
|---------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------|----------------------|--------------------|----------|------|
| TYPE                                        | High-alloyed tubular wire for head resistant Steel. (Typ 25 4, 1.4820),                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                          |                      |                    |          |      |
| APPLICATIONS                                | CEWELD AA 4820 is for welding 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.                                                                                                                                                                                                                                                                                                       |                          |                      |                    |          |      |
| PROPERTIES                                  | Higher productivity, higher deposition rates and improved wetting properties compared to solid wires with comparable analysis. Excellent weld metal quality and X-ray soundness. When welding, care should be taken to minimize the heat input, because materials of this composition have a tendency to embrittle in the temperature range of approx. 600-800° C. The interpass temperature should not exceed 300° C. Therefore, the interpass temperature should not exceed 300°C.                                          |                          |                      |                    |          |      |
| CLASSIFICATION                              | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | 17633-A: TZ 25 4 M M21 1 |                      |                    |          |      |
|                                             | W.Nr.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | 1.4820                   |                      |                    |          |      |
|                                             | FM                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | 5                        |                      |                    |          |      |
| SUITABLE FOR                                | 1.4710, 1.4712, <b>1.4713</b> , 1.4722, <b>1.4724</b> , 1.4729, 1.4740, <b>1.4742</b> , 1.4745, <b>1.4762</b> , 1.4773, 1.4776, 1.4820, <b>1.4821</b> , 1.4822, <b>1.4823</b><br>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<br>AISI 327, ASTM A297HC                                              |                          |                      |                    |          |      |
| APPROVALS                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                          |                      |                    |          |      |
| WELDING POSITIONS                           | <div></div> |                          |                      |                    |          |      |
| TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%) | C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | Si                       | Mn                   | Cr                 | Ni       | Mo   |
|                                             | 0.08                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | 1                        | 0.7                  | 25                 | 4.6      | 0.25 |
| MECHANICAL PROPERTIES                       | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                | R <sub>p0,2</sub> (MPa)  | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Hardness |      |
|                                             | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | >450                     | >650                 | >15                | 94 HB    |      |
| REDRYING                                    | 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 |