



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.					
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	1.4710, 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					
AGRÉMENTS						
POSITIONS DE SOUDAGE						
ANALYSE CHIMIQUE TYPIQUE DU MÉTAL DE SOUDURE (%)	C	Si	Mn	Cr	Ni	Mo
	0.08	1	0.7	25	4.6	0.25
PROPRIÉTÉS MÉCANIQUES	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness	
	As Welded	>450	>650	>15	94 HB	
ETUVAGE	Not required					
GAS ACC. EN ISO 14175	M21					



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AA 4820 1,6MM

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