




CEWELD SACW 4820 (1.4820)

TYPE	High heat resistant stainless steel alloy with low Nickel content for SAW welding.										
APPLICATIONS	Cap layers for joining refractory Cr-Al-Si steels. Cladding corrosion resistant overlays. Cladding heat resistant overlays up to 1150°C. Cladding components in a sulphurous environment.										
PROPERTIES	The weld deposit shows excellent resistance against abrasion at elevated temperatures and can be easily machined. CEWELD® SACW 4820 should be welded with CEWELD® FL 838 SAW flux.										
CLASSIFICATION	W.Nr. 1.4820										
SUITABLE FOR	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										
APPROVALS	No Approvals Found										
WELDING POSITIONS											
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table><thead><tr><th>C</th><th>Mn</th><th>Si</th><th>Cr</th><th>Ni</th></tr></thead><tbody><tr><td>0.07</td><td>0.7</td><td>0.4</td><td>25</td><td>4</td></tr></tbody></table>	C	Mn	Si	Cr	Ni	0.07	0.7	0.4	25	4
C	Mn	Si	Cr	Ni							
0.07	0.7	0.4	25	4							
REDRYING TEMPERATURE	Not required										
GAS ACCORDING EN 14175											



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SACW 4820 (1.4820) 3,2MM

Type	KG/unit	EANCode
S-760	248	8720663415936