







CEWELD 4842 Kb

TYPE	Basic coated electrode for heat resistant stainless steels						
APPLICATIONS	Common applications include industrial furnaces, annealing chambers, fused salt treatment installations and boiler parts, as well as heat exchangers..						
PROPERTIES	For welding heat-resistant austenitic steels of the 25% Cr, 20% Ni types. CEWELD 4842 Kb has good general oxidation resistance, especially at high temperatures, due to its high Cr content. The alloy is fully austenitic and is therefore sensitive to hot cracking. The temperature limits for use under intermittent oxidation depend on cycle frequency. In general the alloy is heat resistant up to 1200 °C. This alloy can withstand relatively severe thermic shock, and is superior to type 309 L.						
CLASSIFICATION	AWS	A 5.4: E 310-15					
	EN ISO	3581-A: E 25 20 B 12					
	F-nr	5					
	FM	5					
	W.Nr.	~1.4842					
SUITABLE FOR	1.4823, 1.4826, 1.4828, 1.4832, 1.4840, 1.4841, 1.4846, 1.4848, 1.4837, 1.4710, 1.4713, 1.4724, 1.4726, 1.4742, 1.4745, 1.4762, 1.4845, 1.4740 X15CrNiSi25-21, X8CrNi25-21, X15CrNiSi20-12, GX15CrNi25-20, X40CrNi25-21, GX40CrNiSi22-10, X10CrAlSi7, X10CrAlSi13, X10CrAlSi18, X10CrAlSi25, GX30CrSi7, GX40CrSi17 AISI 305, 310, 314, ASTM A297 HF, A297 HJ						
APPROVALS	CE						
WELDING POSITIONS	<div>     </div>						
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	P	S	Cr	Ni
	0.1	0.5	2	0.02	0.015	26	21
ALL WELD MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} MPa	R _m MPa	A ₅ (%)	RT	Impact Energy (J) ISO-V -196°C	
	As Welded /	380	570	30	75	37	
REDRYING TEMPERATURE	300°C / 2 hr						
GAS ACCORDING EN 14175							



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4842 KB 2,5 X 300MM

Type	KG/unit	EANCode
Can	2,5	8720663415776