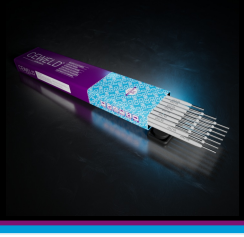


CEWELD 4842 Kb

certilas® THE FILLER METAL SPECIALIST

TYPE

Basic coated electrode for heat resistant stainless steels.(Type25 20, 310)

APPLICATIONS

CEWELD® 4842 Kb is for the dissimilar welding of heat-resistant rolled, forged and cast steels. Common applications include industrial furnaces, annealing chambers, systems for treating molten salts and boiler parts as well as heat exchangers.

PROPERTIES

CEWELD® 4842 Kb has good general oxidation resistance due to its high Cr content, especially at high temperatures. The alloy is fully austenitic and therefore sensitive to hot cracking in the 650-900°C temperature range. The temperature limits for use under intermittent oxidation depend on the frequency of cycling. In general, the alloy is resistant to scaling up to 1200°C. This alloy can withstand relatively strong thermal shocks and is therefore superior to type 309 L. Cold toughness down to - 196°C.

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

ISO 15608: 8.1 Austenitic ≤ 19 % Cr , TÜV 1000: Gr. 21-30, Type: 25% Cr, 22%Ni
1.4710, 1.4713, 1.4724, 1.4726, 1.4742, 1.4745, 1.4762, 1.4823, 1.4826, 1.4828, 1.4832, 1.4835,1.4837, 1.4840, 1.4841, 1.4845, 1.4846, 1.4848, 1.4849, 253MA,
X15CrNiSi 25 20, G-X40CrNiSi 25 12, G-X15CrNi 25 20, X8CrNi25-21, GX40CrNiSi22-10, X15CrNiSi20-12,
310, 310S, CK20, 305, 314, 725LN, 316L ASTM A297 HF / A297HJ
UNS: S31000, S31008, S31050, S31603

APPROVALS

CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S	Cr	Ni
0.1	0.5	2	0.02	0.015	26	21

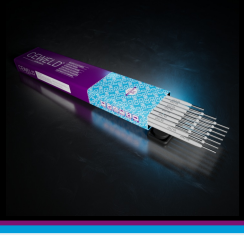
ALL WELD MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ MPa	Rm MPa	A5 (%)	Impact Energy (J) ISO-V 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