



# CEWELD 4115 HLS

**TYPE** High recovery, corrosion resistant stainless steel stick electrode

**APPLICATIONS** Hardfacing shafts from stainless steel parts, molt repairs, rebuilding pump parts etc. Suitable for plating and joining equal and similar ferritic Cr-steels and cast steels. Proper weldings are subject to the recommended heat treatment. This alloy is specially suitable for sealing surfaces on water-, steam and gas-valves, especially for sulphuric gases. The deposit is resistant to seawater, thin acids and scale resistant in air and oxidizing gases up to 950°C . The weld deposit can be tempered.

**PROPERTIES** High deposition rate and excellent weldability on DC +. Stainless steel alloy for joining and cladding 17% Chromium alloys and cladding components where heat and corrosion resistance simmlar to AISI 304 is required. The weld deposit can sustain working temperatures up to 450° C. and will offer a high hardness and wear resistance.

**CLASSIFICATION**

AWS	A 5.4: ~E 430HMo-26
EN ISO	3581-A: ~E Z 17 1 B 42
F-nr	1
FM	5
W.Nr.	1.4115

**SUITABLE FOR** 1.4122 (G)X35CrMo17, 1.4313, 1.4000, 1.4001, 1.4002, Cast steels

**APPROVALS** No Approvals Found

**WELDING POSITIONS**



**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

C	Si	Mn	Cr	Mo
0.18	0.4	0.7	16.6	1

**ALL WELD MECHANICAL PROPERTIES**

Heat Treatment	R <sub>P0,2</sub> MPa	R <sub>m</sub> MPa	A <sub>5</sub> (%)	Hardness Brinell Hardness
As Welded / 720°C±15°C / 2h				Avg. 43 Avg. 200

**REDRYING TEMPERATURE** 300°C / 2 hr

**GAS ACCORDING EN 14175**