





CEWELD 4015 HL-Kb

TYPE	High recovery, Corrosion-resistant stick electrode without nickel. (Type 430, 1.4015)					
APPLICATIONS	CEWELD 4015 HL-Kb is used for joining and cladding 17% chromium alloys and cladding components where heat and corrosion resistance is required. Areas of application are sealing surfaces on gas, water and steam fittings.					
PROPERTIES	CEWELD 4015 HL-Kb can withstand working temperatures of up to 450°C and offers scaling resistance up to 950°C. Preheating at 250 °C and stress relieving at 800 °C is recommended if this is permissible for the base metal. In the machined state there should be at least two weld layers on top of each other. The weld metal can be polished and is scale-resistant up to 900°C. The achievable hardness of the weld metal is mainly influenced by the dilution with the respective base material and its chemical composition. The higher the dilution and the C content of the base material, the higher the hardness of the weld metal. The preheat and interpass temperature should be 200 – 300°C. A tempering 730 – 800°C is possible.					
CLASSIFICATION	AWS	A 5.4: E 430-26				
	EN ISO	3581-A: E 17 B 42				
	F-nr	1				
	FM	5				
	W.Nr.	1.4015				
SUITABLE FOR	1.4000, 1.4002, 1.4016, 1.4057, 1.4740, 1.4742, 1.4057, 1.4059, 1.4741, 1.4509, 1.4510, 1.4511, 1.4512, 1.4520, 1.4712, 1.4713, 1.4724, X7Cr14, X12Cr13, X17CrNi16-2, X6Cr13, X6CrAl13, X6Cr17, X17CrNi16-2, X2CrTiNb18, X3CrTi17, X3CrNb17, X2CrTi12, X2CrTi17, X10CrSi6, X10CrAlSi7, X10CrAlSi13, X10CrAlSi18 UNS S40300, S40500, S40900, S41000, S42900, S43000, S43035, S43036, S43100, S44200 AISI 403, 405, 409, 410, 429, 430, 430Cb, 430Ti, 439, 431, 442					
APPROVALS	CE					
WELDING POSITIONS	<div> PA</div> <div> PB</div> <div> PC</div> <div> PF</div>					
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	Cr	Ni	Mo
	0.09	0.7	0.9	17	0.4	0.3
ALL WELD MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} MPa	R _m MPa	A ₅ (%)	Hardness Brinell Hardness	
	760°C±15°C / 1h	360	540	22	Avg. 200	
	As Welded /				Avg. 250	
REDRYING TEMPERATURE	300°C / 2 hr					
GAS ACCORDING EN 14175						



CEWELD 4015 HL-Kb

4015 HL-KB 3,2 X 350MM

Type	KG/unit	EANCode
Can	2,6	8720663415554

4015 HL-KB 4,0 X 350MM

Type	KG/unit	EANCode
Can	2,6	8720663415561