



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

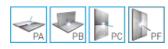
Mn

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



C

TYPICAL CHEMICAL ANALYSIS OF WELD METAL

ANALYSIS OF WELD METAL
(%)

ALL WELD MECHANICAL

PROPERTIES

0.09	0.7	0.9	17	0.4	0.	3
Heat	R _{DO 0} R _D	^5		Hardness		

Cr

Ni

Mο

 Heat
 R_{P0,2} Rm
 A5
 Hardness

 Treatment
 MPa
 MPa
 (%)
 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	Туре	KG/unit	EANCode
	Can	2.6	8720663415561