
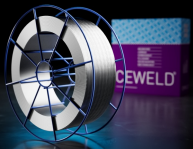


# CEWELD AA 4820

TYPE	High-alloyed tubular wire for heat resistant Steel. (Typ 25 4, 1.4820),												
APPLICATIONS	CEWELD AA 4820 is for welding cap layers for joining refractory Cr-Al-Si steels. Cladding corrosion resistant overlays. Cladding heat resistant overlays up to 1100°C. Cladding components in a sulphurous environment.												
PROPERTIES	Higher productivity, higher deposition rates and improved wetting properties compared to solid wires with comparable analysis. Excellent weld metal quality and X-ray soundness. When welding, care should be taken to minimize the heat input, because materials of this composition have a tendency to embrittle in the temperature range of approx. 600-800° C. The interpass temperature should not exceed 300° C. Therefore, the interpass temperature should not exceed 300°C.												
CLASSIFICATION	EN ISO                    17633-A: TZ 25 4 M M21 1 FM                         5 W.Nr.                    1.4820												
SUITABLE FOR	1.4710, 1.4712, <b>1.4713</b> , 1.4722, <b>1.4724</b> , 1.4729, 1.4740, <b>1.4742</b> , 1.4745, <b>1.4762</b> , 1.4773, 1.4776, 1.4820, <b>1.4821</b> , 1.4822, <b>1.4823</b> G-X30CrSi6, G-X40CrSi23 TP433, X10CrSi6 502, X10CrAl24 TP443, X10CrAl7 502, X8Cr30, X10CrSi13, G-X40CrSi29, X10CrAl13 TP405-CA15, G-X12CrSi 26 5, G-X40CrSi13, X20CrNiSi 25 4 TP329, G-X40CrSi17, G-X40CrNi 25 4 TP329, X10CrAl18 430B-TP430, G-X40CrNiSi 27 4 TP329HC AISI 327, ASTM A297HC												
APPROVALS	No Approvals Found												
WELDING POSITIONS													
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th style="width: 16.6%;">C</th> <th style="width: 16.6%;">Si</th> <th style="width: 16.6%;">Mn</th> <th style="width: 16.6%;">Cr</th> <th style="width: 16.6%;">Ni</th> <th style="width: 16.6%;">Mo</th> </tr> </thead> <tbody> <tr> <td>0.08</td> <td>1</td> <td>0.7</td> <td>25</td> <td>4.6</td> <td>0.25</td> </tr> </tbody> </table>	C	Si	Mn	Cr	Ni	Mo	0.08	1	0.7	25	4.6	0.25
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0.08	1	0.7	25	4.6	0.25								
ALL WELD MECHANICAL PROPERTIES	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th style="width: 25%;">Heat Treatment</th> <th style="width: 12.5%;">R<sub>P0,2</sub> MPa</th> <th style="width: 12.5%;">R<sub>m</sub> MPa</th> <th style="width: 12.5%;">A<sub>5</sub> (%)</th> <th style="width: 37.5%;">Hardness Brinell Hardness</th> </tr> </thead> <tbody> <tr> <td>As Welded /</td> <td></td> <td></td> <td></td> <td>Avg. 94</td> </tr> </tbody> </table>	Heat Treatment	R <sub>P0,2</sub> MPa	R <sub>m</sub> MPa	A <sub>5</sub> (%)	Hardness Brinell Hardness	As Welded /				Avg. 94		
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As Welded /				Avg. 94									
REDRYING TEMPERATURE	Not required												
GAS ACCORDING EN 14175	M21												



# CEWELD AA 4820

AA 4820 1,6MM

Type	KG/unit	EANCode
BS-300	15	8720663415875
Drum	250	8720663415882