



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	<table border="0"> <tr> <td>EN ISO</td> <td>17633-A: TZ 25 4 M M21 1</td> </tr> <tr> <td>FM</td> <td>5</td> </tr> <tr> <td>W.Nr.</td> <td>1.4820</td> </tr> </table>	EN ISO	17633-A: TZ 25 4 M M21 1	FM	5	W.Nr.	1.4820						
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SUITABLE FOR	<p>1.4340, 1.4710, 1.4745, 1.4746, 1.4712, 1.4762, 1.4713, 1.4773, 1.4722, 1.4776, 1.4724, 1.4820, 1.4729, 1.4821, 1.4740, 1.4822, 1.4742, 1.4823</p> <p>GX40CrNi27-4, G-X30CrSi6, G-X40CrSi23, X10CrSi6 502, X10CrAl24, X10CrAl7, X8Cr30, X10CrSi13, G-X40CrSi29, X8CrTi25, X10CrAl13, G-X12 CrSi 26 5, G-X40CrSi13, X20 CrNiSi 25 4, G-X40CrSi17, G-X40CrNi 25 4, X10CrAl18, G-X40CrNiSi 27 4, AISI 327, 442, 446, ASTM A 297 HC, UNS S44200, 44600, J92605, J93005, J92605</p>												
APPROVALS	No Approvals Found												
WELDING POSITIONS													
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>Cr</th> <th>Ni</th> <th>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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ALL WELD MECHANICAL PROPERTIES	<table border="1"> <thead> <tr> <th>Heat Treatment</th> <th>R_{p0,2} MPa</th> <th>R_m MPa</th> <th>A₅ (%)</th> <th>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 _{p0,2} MPa	R _m MPa	A ₅ (%)	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