CEWELD AA 4820

certilas® THE FILLER METAL SPECIALIST

TYPE

High-alloyed tubular wire for head 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, **1.4713**, 1.4722, **1.4724,** 1.4729, 1.4740, **1.4742**, 1.4745, **1.4762,** 1.4773, 1.4776, 1.4820, **1.4821**, 1.4822, **1.4823**
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 (%)

C	Si	Mn	Cr	Ni	Mo
0.08	1	0.7	25	4.6	0.25

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ MPa	Rm MPa	A5 (%)	Hardness Brinell Hardness
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