



CEWELD 4853 Kb

TYPE	Basic electrode for heat resistant stainless steel SMAW welding.														
APPLICATIONS	CEWELD® 4853 Kb is designed for joining and hardfacing high-temperature CrNi steels of the same or similar types and cast steels in low-sulphur environments.														
PROPERTIES	CEWELD® 4853 Kb is characterized by high corrosion resistance and excellent weldability for both AC and DC+. The weld metal is scale resistant up to 1050 °C.														
CLASSIFICATION	<table border="0"> <tr> <td>EN ISO</td> <td>3581-A: E Z 25 35 Nb B 32</td> </tr> <tr> <td>FM</td> <td>5</td> </tr> <tr> <td>W.Nr.</td> <td>1.4853</td> </tr> </table>	EN ISO	3581-A: E Z 25 35 Nb B 32	FM	5	W.Nr.	1.4853								
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W.Nr.	1.4853														
SUITABLE FOR	(1.4806), 1.4837, 1.4848, 1.4849, 1.4852, 1.4853, 1.4857, G-X 40 NiCrNb 35 25, G-X 40 NiCrSi 35 25, G-X40CrNiSi25-12, G-X40CrNiSi25--20, G-X40NiCr38-18, G-X40NiCrNb35-25, HK40, HK45, UNS: J93503, J94204, N08705 J 94013, J 94003, J 93633, J 93513, J 93503, J 94224, J 94204, J 94203, N 08005, N 08004, N 08705														
APPROVALS	CE														
WELDING POSITIONS															
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <td>C</td> <td>Si</td> <td>Mn</td> <td>P</td> <td>S</td> <td>Cr</td> <td>Ni</td> </tr> <tr> <td>0.4</td> <td>0.9</td> <td>1</td> <td>0.025</td> <td>0.015</td> <td>26</td> <td>35</td> </tr> </table>	C	Si	Mn	P	S	Cr	Ni	0.4	0.9	1	0.025	0.015	26	35
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ALL WELD MECHANICAL PROPERTIES	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <td>Heat Treatment</td> <td>R_{p0,2} MPa</td> <td>R_m MPa</td> <td>A₅ (%)</td> </tr> <tr> <td>As Welded /</td> <td>500</td> <td>700</td> <td>10</td> </tr> </table>	Heat Treatment	R _{p0,2} MPa	R _m MPa	A ₅ (%)	As Welded /	500	700	10						
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As Welded /	500	700	10												
REDRYING TEMPERATURE	300°C / 2 hr														
GAS ACCORDING EN 14175															



CEWELD 4853 Kb

4853 KB 3,2 X 350MM

Type	KG/unit	EANCode
Can	2,8	8720663415820

4853 KB 4,0 X 350MM

Type	KG/unit	EANCode
Can	3,0	8720663424518