



CEWELD 4850 Kb

TYPE Basic electrode for heat resistant stainless steel SMAW welding

APPLICATIONS CEWELD® 4850 Kb for repair and build-up welding of same and similar types of heat-resistant steels and cast steels.

PROPERTIES CEWELD® 4850 Kb has high corrosion resistance and excellent weldability for both AC and DC+. The weld metal can be used up to 1050 °C in carburized and low-sulphur environments.

CLASSIFICATION EN ISO 3581-A: E Z 21 33 Nb B 32
FM 5
W.Nr. ~1.4850

SUITABLE FOR 1.4876, 1.4861, 1.4859, 1.4958, 1.4959,
G-X10NiCrNb 32 20, X10NiCrAlTi 32 20, X5NiCrAlTi 31 20, X8NiCrAlTi 31 21,
UNS N 08800, N 08810, N 08811, Alloy 800H

APPROVALS CE

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S	Cr	Ni
0.15	0.5	4.5	0.02	0.01	22	34

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V RT
As Welded /	380	600	25	50

REDRYING TEMPERATURE 300°C / 2 hr

GAS ACCORDING EN 14175



CEWELD 4850 Kb

4850 KB 2,5 X 350MM

Type	KG/unit	EANCode
Can	2,8	8720663415813