


CEWELD 4842 Ti

TYPE	Rutile-coated stick electrode for heat-resistant stainless steels. (Type 25 20, 310)																
APPLICATIONS	CEWELD® 4842 Ti is for the dissimilar welding of heat-resistant rolled, forged and cast steels. Common applications include industrial furnaces, annealing chambers, systems for treating molten salts and boiler parts as well as heat exchangers.																
PROPERTIES	CEWELD 4842 Ti has good general oxidation resistance, especially at high temperatures, due to its high Cr content. The alloy is fully austenitic and is therefore sensitive to hot cracking. The temperature limits for use under intermittent oxidation depend on cycle frequency. In general the alloy is heat resistant up to 1200 °C. This alloy can withstand relatively severe thermic shock, and is superior to type 309 L.																
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.4: E 310-16</td> </tr> <tr> <td>EN ISO</td> <td>3581-A: E 25 20 R 12</td> </tr> <tr> <td>F-nr</td> <td>5</td> </tr> <tr> <td>FM</td> <td>5</td> </tr> <tr> <td>W.Nr.</td> <td>~1.4842</td> </tr> </table>	AWS	A 5.4: E 310-16	EN ISO	3581-A: E 25 20 R 12	F-nr	5	FM	5	W.Nr.	~1.4842						
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SUITABLE FOR	1.4823, 1.4826, 1.4828, 1.4832, 1.4840, 1.4841, 1.4846, 1.4848, 1.4837, 1.4710, 1.4713, 1.4724, 1.4726, 1.4742, 1.4745, 1.4762, 1.4845, 1.4740 X15CrNiSi25-21, X8CrNi25-21, X15CrNiSi20-12, GX15CrNi25-20, X40CrNi25-21, GX40CrNiSi22-10, X10CrAlSi7, X10CrAlSi13, X10CrAlSi18, X10CrAlSi25, GX30CrSi7, GX40CrSi17 AISI 305, 310, 314, ASTM A297 HF, A297 HJ																
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>P</th> <th>S</th> <th>Cr</th> <th>Ni</th> <th>Fe</th> </tr> </thead> <tbody> <tr> <td>0.1</td> <td>0.6</td> <td>2</td> <td>0.02</td> <td>0.015</td> <td>26</td> <td>21</td> <td>Rem.</td> </tr> </tbody> </table>	C	Si	Mn	P	S	Cr	Ni	Fe	0.1	0.6	2	0.02	0.015	26	21	Rem.
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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>Impact Energy (J) ISO-V RT</th> </tr> </thead> <tbody> <tr> <td>As Welded /</td> <td>380</td> <td>600</td> <td>30</td> <td>75</td> </tr> </tbody> </table>	Heat Treatment	R _{p0,2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V RT	As Welded /	380	600	30	75						
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As Welded /	380	600	30	75													
REDRYING TEMPERATURE	300°C / 2 hr																
GAS ACCORDING EN 14175																	



CEWELD 4842 Ti

4842 TI 2,0 X 300MM

Type	KG/unit	EANCode
Can	2,6	8720663415752

4842 TI 2,5 X 300MM

Type	KG/unit	EANCode
Can	2,5	8720663415769

4842 TI 3,2 X 350MM

Type	KG/unit	EANCode
Can	2,8	8720663415783

4842 TI 4,0 X 350MM

Type	KG/unit	EANCode
Can	3,0	8720663415790

4842 TI 5,0 X 350MM

Type	KG/unit	EANCode
Can	2,5	8720663415806