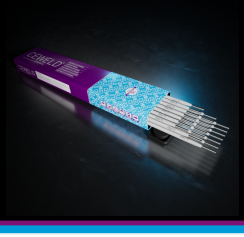


CEWELD 4842 Ti

certilas® THE FILLER METAL SPECIALIST

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

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

SUITABLE FOR

ISO 15608: 8.1 Austenitic ≤ 19 % Cr , TÜV 1000: Gr. 21-30, Type: 25% Cr, 22%Ni
1.4710, 1.4713, 1.4724, 1.4726, 1.4742, 1.4745, 1.4762, 1.4823, 1.4826, 1.4828, 1.4832, 1.4835,1.4837, 1.4840, 1.4841, 1.4845, 1.4846, 1.4848, 1.4849, 253MA, X15CrNiSi 25 20, G-X40CrNiSi 25 12, G-X15CrNi 25 20, X8CrNi25-21, GX40CrNiSi22-10, X15CrNiSi20-12,
310, 310S, CK20, 305, 314, 725LN, 316L ASTM A297 HF / A297HJ
UNS: S31000, S31008, S31050, S31603

APPROVALS

No Approvals Found

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S	Cr	Ni	Fe
0.1	0.6	2	0.02	0.015	26	21	Rem.

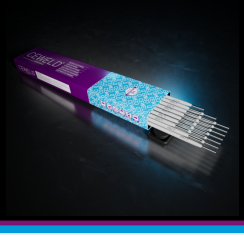
ALL WELD MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ MPa	Rm MPa	A5 (%)	Impact Energy (J) ISO-V RT
As Welded /	380	600	30	75

REDRYING TEMPERATURE

300°C / 2 hr

GAS ACCORDING EN 14175



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	Type	KG/unit	EANCode
4842 TI 2,0 X 300MM	Can	2,6	8720663415752
4842 TI 2,5 X 300MM	Can	2,5	8720663415769
4842 TI 3,2 X 350MM	Can	2,8	8720663415783
4842 TI 4,0 X 350MM	Can	3,0	8720663415790
4842 TI 5,0 X 350MM	Can	2,5	8720663415806