




CEWELD 4829 MoTi

TYPE	Austenitic rutile stick electrode for welding Cr-Ni-Mo steels. (Type E 23 12 2 L R / E309LMo)																	
APPLICATIONS	CEWELD® 4829 MoTi is for joining heat resistant CrNi-steels of the same kind and also joining dissimilar alloys such as steel to stainless steel. Cladding on low alloyed steels in case a 18/8/2 CrNiMo layer is required in the first layer.																	
PROPERTIES	The increased ferrite content (FN~19) in the weld metal of CEWELD® 4829 MoTi enables high crack resistance with materials that are less suitable for welding. Particularly easy processing with very good seam appearance, both with direct and alternating current. Self-lifting slag. For application temperatures from -60°C to 300°C, for 1st layer weld claddings up to 400°C.																	
CLASSIFICATION	AWS	A 5.4: E 309LMo-16																
	EN ISO	3581-A: E 23 12 2 L R 32																
	F-nr	1																
	FM	5																
	W.Nr.	1.4459																
SUITABLE FOR	23% Cr, 12%Ni, 3% Mo, 309LMo 1.4401, 1.4404, 1.4406, 1.4410, 1.4437, 1.4571, 1.4580, 1.4459, 1.4513, 1.4521, 1.4526, 1.4113, 1.4575 AISI 436, 444, 434 UNS S43600, S 44400, S43400,																	
APPROVALS	CE																	
WELDING POSITIONS																		
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> </tr> </thead> <tbody> <tr> <td>0.02</td> <td>0.7</td> <td>1.8</td> <td>0.02</td> <td>0.015</td> <td>24</td> <td>13</td> <td>2.5</td> </tr> </tbody> </table>		C	Si	Mn	P	S	Cr	Ni	Mo	0.02	0.7	1.8	0.02	0.015	24	13	2.5
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ALL WELD MECHANICAL PROPERTIES	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th>R_{p0,2}</th> <th>R_m</th> <th>A₅</th> <th rowspan="2">Impact Energy (J) ISO-V</th> </tr> <tr> <th>MPa</th> <th>MPa</th> <th>(%)</th> </tr> </thead> <tbody> <tr> <td>As Welded /</td> <td>460</td> <td>650</td> <td>32</td> <td>55</td> </tr> </tbody> </table>		Heat Treatment	R _{p0,2}	R _m	A ₅	Impact Energy (J) ISO-V	MPa	MPa	(%)	As Welded /	460	650	32	55			
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As Welded /	460	650	32	55														
REDRYING TEMPERATURE	300°C / 2 hr																	
GAS ACCORDING EN 14175																		



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4829 MOTI 2,0 X 300MM

Type	KG/unit	EANCode
Can	2,4	8720663415707

4829 MOTI 2,5 X 300MM

Type	KG/unit	EANCode
Can	2,5	8720663415714

4829 MOTI 3,2 X 350MM

Type	KG/unit	EANCode
Can	2,8	8720663415721

4829 MOTI 4,0 X 350MM

Type	KG/unit	EANCode
Can	2,8	8720663415738

4829 MOTI 5,0 X 450MM

Type	KG/unit	EANCode
Can	3,0	8720663415745