




CEWELD 4539 Ti

TYPE	Rutile basic electrode for welding Cr-Ni-Mo-Cu steels with very low C-content.																		
APPLICATIONS	<p>CEWELD® 4539 Ti is designed for joining exceptional corrosion resistant CrNiMoCu- steels at temperatures to 350 °C.</p> <p>Used in highly corrosive environments encountered in e.g. sulfur and phosphorus production, pulp & paper industry, fl ue gas desulfurization plants; desalination plants, fertilizer production and petrochemical industry; acetic and formic acid production, in pickling plants as well as heat exchangers and power plants using brackish or seawater.</p>																		
PROPERTIES	The weld deposit from CEWELD® 4539 Ti offers excellent corrosion resistance especially against Phosphor acid. The weld deposit is capable of taking a high polish																		
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.4: E 385-26</td> </tr> <tr> <td>EN ISO</td> <td>3581-A: E 20 25 5 Cu L R 32</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>1.4539</td> </tr> </table>	AWS	A 5.4: E 385-26	EN ISO	3581-A: E 20 25 5 Cu L R 32	F-nr	5	FM	5	W.Nr.	1.4539								
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FM	5																		
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SUITABLE FOR	<p>1.4539 / 904L CrNiMoCu / 20 25 5 Cu L</p> <p>1.4465, 1.4500, 1.4505, 1.4506, 1.4519, 1.4531, 1.4536, 1.4537, 1.4538, 1.4539, 1.4573, 1.4585, 1.4586</p> <p>X1CrNiMoN25-25-2, X1NiCrMoCu 25-20-5, X1CrNiMoCuN 25-25-5, X2NiCrMoCuN25-20-5, X2NiCrMoCuN20-18, X4NiCrMoCuNb 20-18-2, X5NiCrMoCuTi20-18, X5NiCrMoCuNb22-18</p> <p>ASTM A182, UNS N08904, S31726 Uranus B6, AISI 904L, Z2NCDU25-20,</p>																		
APPROVALS	CE																		
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>Mo</th> <th>Cu</th> </tr> </thead> <tbody> <tr> <td>0.02</td> <td>0.7</td> <td>2</td> <td>0.02</td> <td>0.1</td> <td>20.5</td> <td>25</td> <td>5</td> <td>1.8</td> </tr> </tbody> </table>	C	Si	Mn	P	S	Cr	Ni	Mo	Cu	0.02	0.7	2	0.02	0.1	20.5	25	5	1.8
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As Welded /	410	600	30	RT 40															
REDRYING TEMPERATURE	300°C / 2 hr																		
GAS ACCORDING EN 14175																			



CEWELD 4539 Ti

4539 TI 2,5 X 300MM

Type	KG/unit	EANCode
Can	2,8	8720663413215

4539 TI 3,2 X 350MM

Type	KG/unit	EANCode
Can	3,0	8720663413222

4539 TI 4,0 X 350MM

Type	KG/unit	EANCode
Can	3,0	8720663413239