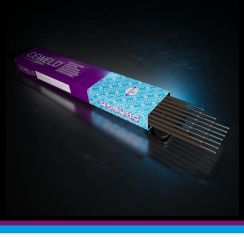

CEWELD E Alloy 22H

certilas® THE FILLER METAL SPECIALIST

TYPE

Basic coated special electrode for high temperature cast steel.

APPLICATIONS

CEWELD E Alloy 22H is used for joining and build-up welding on identical or similar high-alloy 0,5%C-28%Cr- 50%Ni-5%W high-temperature cast materials, e.g. M.no. 2.4879 (G-NiCr28W). The main application is centrifugally cast pipes for furnaces in the petrochemical industry with operating temperatures up to 1150°C. Furnace parts, sintering and calcining muffles, cement kiln components resistant to hot abrasion, radiant tubes and pyrolysis coils.

PROPERTIES

CEWELD E Alloy 22H is characterized by a quiet and stable arc. Good slag removability and fine flaky seam pattern. The weld metal is high-temperature resistant with very good creep resistance. High nickel gives the alloy good resistance to carburisation and under oxidising conditions high chromium provides useful resistance to sulphidation

CLASSIFICATION

DIN	1736: EL-NiCr28W (mod)
W.Nr.	2.4879

SUITABLE FOR

2.4879
G NiCr28W, G-X45NiCrWSi 48 28
Duraloy 22H, Duraloy Super 22H (+2%Co), Paralloy H48T, Centralloy 4879, Marker G4879, Pyrotherm G 28/48/5W,
Cronite HR23, Lloyds T75, Thermax 70, Manaurite 50W, Thermalloy T75

APPROVALS

No Approvals Found

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Cr	Ni	W	Fe
0.5	0.8	1.2	29	50	4.5	14

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ MPa	Rm MPa	A5 (%)		Hardness Vickers
As Welded /	480	650	5		Avg. 270

REDRYING TEMPERATURE

300°C / 2 hr

GAS ACCORDING EN 14175