



CEWELD E Alloy 22H

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 | R _m MPa | A ₅ (%) | Hardness Vickers |
|----------------|-----------------------|--------------------|--------------------|------------------|
| As Welded / | 480 | 650 | 5 | Avg. 270 |

REDRYING TEMPERATURE 300°C / 2 hr

GAS ACCORDING EN 14175