



CEWELD AA 4820

TYPE High-alloyed tubular wire for heat resistant Steel. (Typ 25 4, 1.4820),

APPLICATIONS CEWELD AA 4820 is for welding cap layers for joining refractory Cr-Al-Si steels. Cladding corrosion resistant overlays. Cladding heat resistant overlays up to 1100°C. Cladding components in a sulphurous environment.

PROPERTIES Higher productivity, higher deposition rates and improved wetting properties compared to solid wires with comparable analysis. Excellent weld metal quality and X-ray soundness. When welding, care should be taken to minimize the heat input, because materials of this composition have a tendency to embrittle in the temperature range of approx. 600-800° C. The interpass temperature should not exceed 300° C. Therefore, the interpass temperature should not exceed 300°C.

CLASSIFICATION

EN ISO	17633-A: TZ 25 4 M M21 1
W.Nr.	1.4820
FM	5

SUITABLE FOR 1.4340, 1.4710, 1.4745, 1.4746, 1.4712, 1.4762, 1.4713, 1.4773, 1.4722, 1.4776, 1.4724, 1.4820, 1.4729, 1.4821, 1.4740, 1.4822, 1.4742, 1.4823
 GX40CrNi27-4, G-X30CrSi6, G-X40CrSi23, X10CrSi6 502, X10CrAl24, X10CrAl7, X8Cr30, X10CrSi13, G-X40CrSi29, X8CrTi25, X10CrAl13, G-X12 CrSi 26 5, G-X40CrSi13, X20 CrNiSi 25 4, G-X40CrSi17, G-X40CrNi 25 4, X10CrAl18, G-X40CrNiSi 27 4,
 AISI 327, 442, 446, ASTM A 297 HC
 UNS S44200, 44600, J92605, J93005, J92605

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Cr	Ni	Mo
0.08	1	0.7	25	4.6	0.25

MECHANICAL PROPERTIES

Heat Treatment	R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness
As Welded	>450	>650	>15	94 HB

REDRYING Not required

GAS ACC. EN ISO 14175 M21



CEWELD AA 4820

AA 4820 1,6MM

Packaging	KG/unit	EanCode
BS-300	15	8720663415875
Drum	250	8720663415882