



CEWELD 4820 AC

TYPE	High Chromium electrode for high temperature applications.						
APPLICATIONS	CEWELD® 4820 AC is a cored wire alloyed, AC weldable stick electrode (Preferred =+) for production and repair welding on similar or similar, corrosion and heat resistant steels and steel castings. For furnaces requiring improved resistance to reducing and oxidizing sulfurous gases as well as for final passes of weld joints. Scaling resistant up to 1100°C.						
PROPERTIES	CEWELD® 4820 AC is scale-resistant on the same base material and, due to its low nickel content, is resistant to attack by sulphur gases and oxidizing combustion gases up to 1100°C. When welding CEWELD® 4820 AC, a low heat input is required, as alloys of this chemistry tend to become brittle at 600-800°C. The preheating temperature for similar and dissimilar steels should be 100 - 200°C, depending on composition and material thickness. The interpass temperature should not exceed 300°C.						
CLASSIFICATION	EN ISO	3581-A: E 25 4 R 32					
	W.Nr.	1.4820					
	FM	5					
SUITABLE FOR	Mo-free 25Cr(Ni) alloys 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	CE						
WELDING POSITIONS							
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	P	S	Cr	Ni
	0.1	1	2	0.02	0.01	26	5
MECHANICAL PROPERTIES	Heat Treatment		R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness	
	As Welded		500	700	20	180 HB	
REDRYING	300°C / 2 hr						
GAS ACC. EN ISO 14175							



CEWELD 4820 AC

4820 AC 2,5 X 350MM

Packaging	KG/unit	EanCode
Can	2,5	8720663415660

4820 AC 3,2 X 350MM

Packaging	KG/unit	EanCode
Can	2,5	8720663415653