



CEWELD 4539 Ti

TYPE Rutile basic electrode for welding Cr-Ni-Mo-Cu steels with very low C-content.

APPLICATIONS CEWELD® 4539 Ti is designed for joining exceptional corrosion resistant CrNiMoCu- steels at temperatures from -196 °C to 350 °C.
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.

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

AWS	A 5.4: E 385-26
EN ISO	3581-A: E 20 25 5 Cu L R 32
W.Nr.	1.4539
F-nr	5
FM	5

SUITABLE FOR 1.4500, 1.4505, 1.4506, 1.4519, 1.4531, 1.4536, 1.4537, 1.4538, 1.4539, 1.4573, 1.4585, 1.4586, 4 NS N 08904
X4NiCrMoCuNb20-18-2, X5NiCrMoCuTi20-18, X1CrNiMoCuN25-25-5, X2NiCrMoCuN20-18, X1NiCrMoCu25-20-5, X5NiCrMoCuNb22-18
UNS S31726, N08904
AISI 904L

APPROVALS CE

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S	Cr	Ni	Mo	Cu
0.02	0.7	2	0.02	0.1	20.5	25	5	1.8

MECHANICAL PROPERTIES

Heat Treatment	R _{P0,2} (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V	Hardness
				RT	
As Welded	410	600	30	40	HRc

REDRYING 300°C / 2 hr

GAS ACC. EN ISO 14175



CEWELD 4539 Ti

4539 Ti 2,5 X 300MM

Packaging	KG/unit	EanCode
Can	2,8	8720663413215

4539 Ti 3,2 X 350MM

Packaging	KG/unit	EanCode
Can	3,0	8720663413222

4539 Ti 4,0 X 350MM

Packaging	KG/unit	EanCode
Can	3,0	8720663413239