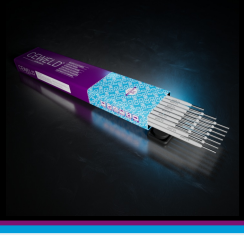


CEWELD 4460 Cu

certilas® THE FILLER METAL SPECIALIST

TYPE

Rutile-Basic stainless steel electrode with extreme high corrosion resistance and mechanical properties.

APPLICATIONS

CEWELD® 4460 Cu is for welding super duplex stainless steels. Same type welding between super duplex stainless steels and between other stainless and unalloyed or low alloy steels. CEWELD® 4460 Cu is used wherever a combination of good corrosion resistance and high strength is required.

PROPERTIES

CEWELD® 4460 Cu has an austenitic-ferritic microstructure for surfacing and joint welding on super duplex steels. Application temperature ≤ 250 C°

CLASSIFICATION

AWS	A 5.4: E 2593-16
EN ISO	3581-A: E 25 9 4 N L
W.Nr.	1.4501
F-nr	4
FM	5

SUITABLE FOR

welding Super Duplex 2593
1.4410, 1.4460, 1.4467, 1.4468, 1.4501, 1.4507, 1.4515, 1.4517
X2CrNiMoN25-7-4, X2CrMnNiMoN26-5-4, GX2CrNiMoN25-6-3, X2CrNiMoCuWN25-7-4, X2CrNiMoCuN25-6-3, GX2CrNiMoCuN26-6-3, GX2CrNiMoCuN25-6-3-3
UNS S32750, S32760, J93380, S32520, S32550, S39274, S32950
SAF 25/07, S32750 1.4410 - 25Cr-7Ni-4Mo-0.28N SAF2507, NAS74N, S32760 1.4501 - 25Cr-7Ni-3.8Mo-0.7Cu-0.7W-0.25N, S32506 - SUS329J4L 25Cr-7Ni-3Mo-0.15N-0.2W NAS64 1.4507, S31803, S32205,
Ferralium 255, Super Duplex steels, ZERON 100

APPROVALS

CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S	Cr	Ni	Mo	N	W	Cu
0.02	0.8	1.1	0.02	0.015	26	9.5	3.5	0.2	0.6	0.8

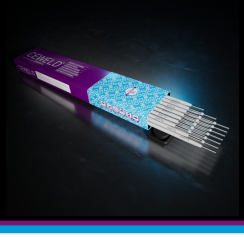
MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V	Hardness
				RT	
As Welded	560	760	20	50	HRc

REDRYING

300°C / 2 hr

GAS ACC. EN ISO 14175



CEWELD 4460 Cu

certilas® THE FILLER METAL SPECIALIST

4460 CU 2,5 X 300MM

Packaging	KG/unit	EanCode
Can	2,5	8720663413185

4460 CU 3,2 X 350MM

Packaging	KG/unit	EanCode
Can	2,6	8720663413192

4460 CU 4,0 X 350MM

Packaging	KG/unit	EanCode
Can	2,8	8720663413208