



CEWELD 4820 AC

TYPE	High Chromium electrode for high temperature applications.														
APPLICATIONS	CEWELD® 4820 AC is a high-alloy rod electrode with an alloyed core rod (preferably =+), which can be welded with alternating current and is suitable for production and repair welding work on similar or similar corrosion- and heat-resistant steels and steel castings. For furnaces that require improved resistance to reducing and oxidizing sulfur-containing gases, as well as for the final welding of welded joints. Resistant to spalling 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	<table border="0"> <tr> <td>EN ISO</td> <td>3581-A: E 25 4 R 32</td> </tr> <tr> <td>W.Nr.</td> <td>1.4820</td> </tr> <tr> <td>FM</td> <td>5</td> </tr> </table>	EN ISO	3581-A: E 25 4 R 32	W.Nr.	1.4820	FM	5								
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SUITABLE FOR	<p>Mo-free 25Cr(Ni) alloys 1.4710, 1.4712, 1.4713, 1.4722, 1.4724, 1.4729, 1.4740, 1.4742, 1.4745, 1.4762, 1.4773, 1.4776, 1.4820, 1.4821, 1.4822, 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</p>														
APPROVALS	CE														
WELDING POSITIONS															
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</th> <th>Cr</th> <th>Ni</th> </tr> </thead> <tbody> <tr> <td>0.1</td> <td>1</td> <td>2</td> <td>0.02</td> <td>0.01</td> <td>26</td> <td>5</td> </tr> </tbody> </table>	C	Si	Mn	P	S	Cr	Ni	0.1	1	2	0.02	0.01	26	5
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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