



# CEWELD 4460 Cu

|                                             |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                         |                      |                    |                         |    |     |     |     |          |     |
|---------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------|----------------------|--------------------|-------------------------|----|-----|-----|-----|----------|-----|
| TYPE                                        | Rutile-Basic stainless steel electrode with extreme high corrosion resistance and mechanical properties.                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                         |                      |                    |                         |    |     |     |     |          |     |
| TOEPASSINGEN                                | Welding wrought, forged or cast super duplex stainless steels for service in the as-welded condition. Heterogeneous welding between super duplex stainless steels and dissimilar welds between other stainless and mild or low alloyed steels                                                                                                                                                                                                                                                                                                                         |                         |                      |                    |                         |    |     |     |     |          |     |
| EIGENSCHAPPEN                               | Higher corrosion resistance than standard Duplex steels with also higher mechanical properties due to the addition of Nitrogen.                                                                                                                                                                                                                                                                                                                                                                                                                                       |                         |                      |                    |                         |    |     |     |     |          |     |
| CLASSIFICATIE                               | 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                       |                      |                    |                         |    |     |     |     |          |     |
| GESCHIKT VOOR                               | <b>welding Super Duplex 2593</b><br>1.4410, 1.4460, 1.4467, 1.4468, 1.4501, 1.4507, 1.4515, 1.4517<br>X2CrNiMoN25-7-4, X2CrMnNiMoN26-5-4, GX2CrNiMoN25-6-3, X2CrNiMoCuWN25-7-4, X2CrNiMoCuN25-6-3, GX2CrNiMoCuN26-6-3, GX2CrNiMoCuN25-6-3-3<br><b>UNS</b> S32750, S32760, J93380, S32520, S32550, S39274, S32950<br><b>SAF</b> 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,<br>Ferrallium 255, Super Duplex steels, ZERON 100 |                         |                      |                    |                         |    |     |     |     |          |     |
| GOEDKEURINGEN                               | CE                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |                         |                      |                    |                         |    |     |     |     |          |     |
| LASPOSITIES                                 |                                                     |                         |                      |                    |                         |    |     |     |     |          |     |
| 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 |
| MECHANISCHE WAARDEN                         | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | R <sub>P0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Impact Energy (J) ISO-V |    |     |     |     | Hardness |     |
|                                             |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                         |                      |                    | RT                      |    |     |     |     |          |     |
|                                             | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | 560                     | 760                  | 20                 | 50                      |    |     |     |     | HRc      |     |
| HERDROGEN                                   | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                         |                      |                    |                         |    |     |     |     |          |     |
| GAS ACC. EN ISO 14175                       |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                         |                      |                    |                         |    |     |     |     |          |     |



# CEWELD 4460 Cu

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 |