

4539 Ti

CATEGORY SMAW Stick Electrodes

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

APPLICATIONS Designed for joining exceptional corrosion resistant CrNiMoCu- steels at temperatures from -196° C to 350° C.

PROPERTIES The weld deposit offers excellent corrosion resistance especially against Phosphor acid. The weld deposit is capable of taking a high polish

CLASSIFICATION

AWS	A 5.4: E 385-16
EN ISO	3581-A: E 20 25 5 Cu N L R 53
DIN: W.Nr.	1.4539
DIN	8556: E 20 25 5CuLR23

SUITABLE FOR W.Nrs: 1.4500, 1.4505, 1.4506, 1.4519, 1.4531, 1.4536, 1.4539, 1.4573, 1.4585, 1.4586, 4 NS N 08904 904L

APPROVALS CE approved

WELDING POSITIONS:



WELD DEPOSIT WEIGHT %

C	Mn	Si	Cr	Ni	Mo	Cu	Fe
<0.03	1.2-1.8	0.5	19-21	24-26	4-5	1.2-1.8	Rem

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				20°C	-40°C	-60°C	
AW	380-430	590-610	32-35	30-50			

AW: as welded

WELDING PARAMETERS PACKING

D (mm)	Welding Parameters			Packing		
	Length (mm)	Current (A)	kg / can	kg / 6pack	kg / 1000	
2.5	300	60-90	2.8	16.8	18.8	
3.2	350	80-110	3	18	35.6	
4.0	350	100-150	3	18	54	

REDRYING TEMPERATURE 300°C/2hr (not often required).