

## 4830 Kb

<b>CATEGORY</b>	SMAW Stick Electrodes
<b>TYPE</b>	Basic electrode for heat resistant stainless steel SMAW welding.
<b>APPLICATIONS</b>	Joining and cladding of fully austenitic heat resistant CrNi-steels of the same kind and similar Cast steels.
<b>PROPERTIES</b>	High corrosion resistance and excellent weldability on both AC and DC+. The weld deposit is scale resistant up to 1000°C

<b>CLASSIFICATION</b>	AWS	A 5.4:
	EN ISO	3581-A: EZ 25 24 Nb B 32 1600: EZ 25 24 Nb B 32
	DIN: W.Nr.	1.4830
	DIN	8555:

<b>SUITABLE FOR</b>	W.Nr: 1.4855, 1.4845
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<b>APPROVALS</b>	CE approved
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<b>WELDING POSITIONS:</b>	
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<b>WELD DEPOSIT WEIGHT %</b>					
C	Cr	Ni	Nb	Fe	
<0.25	24-26	23-25	0.9-1.2	rem	

<b>ALL WELD MECHANICAL PROPERTIES</b>							
Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				-20°C	-40°C	-60°C	
AW	>400	>600	>10				

AW: as welded

<b>WELDING PARAMETERS / PACKING</b>					
Welding Parameters			Packing		
D (mm)	Length (mm)	Current (A)	kg / can	kg / 6pack	kg / 1000
2.5	300	60-90	2.5	15	21
3.2	350	80-110	2.8	16.8	39
4.0	350	100-150	3.0	18	70

<b>REDRYING TEMPERATURE</b>	320°C/2hr .
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