CEWELD®

AA 4820

CATEGORY	FCAW Flux-Cored
TYPE	High-alloyed tubular wire based on a 25% Chromium and 4% Nickel deposit for cladding and joining components against corrosion, high-heat and wear resistance. Developed for gas shielded arc welding.
APPLICATIONS	- Cap layers for joining refractory Cr-Al-Si steels. - Cladding corrosion resistant overlays. - Cladding heat resistant overlays up to 1100ºC. - Cladding components in a sulphurous environment.
PROPERTIES	Higher productivity, higher deposition rates and improved wetting properties compared to solid wires with comparable analysis. Excellent weld metal quality and X-ray soundness.
CLASSIFICATION	AWS A 5.22: EN ISO 12073: TZ 25 4 MM 1 DIN: W.Nr. 1.4820 DIN 8556: 25 4
SUITABLE FOR	1.4710 G-X30CrSi6, 1.4745 G-X40CrSi23 TP433, 1.4712 X10CrSi6 502, 1.4762 X10CrAl24 TP443, 1.4713 X10CrAl7 502, 1.4773 X8Cr30, 1.4722 X10CrSi13, 1.4776 G-X40CrSi29, 1.4724 X10CrAl13 TP405-CA15, 1.4820 G-X12 CrSi 26 5, 1.4729 G-X40CrSi13 , 1.4821 X20 CrNiSi 25 4 TP329, 1.4740 G-X40CrSi17 , 1.4822 G-X40CrNi 25 4 TP329, 1.4742 X10CrAl18 430B-TP430 1.4823 G-X40CrNiSi 27 4 TP329HC
APPROVALS	CE approved
WELDING POSITIONS:	

ALL WELD-METAL ANALYSES %

C	Mn	Si	Cr	Ni	P	S
0.08	0.70	0.80	25.00	4.00	0.020	0.008

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (N/mm²)	Rm (N/mm²)	A5 (%)	Impact Energy (J) ISO-V +20°C	-40°C	-60°C	Hardness HRc / HV
AW	570	750	20	40			

AW = as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool	kg / pallet
1.2	22-32	150-290	SD-300 / Drum	15 / 250	1080 / 1000
1.6	24-38	200-390	SD-300 / Drum	15 / 250	1080 / 1000

REDRYING TEMPERATURE	150°C / 24hr
GAS ACC. EN ISO 14175:	M21