

## SACW 4820 (1.4820)

**CATEGORY** SAW Arc Submerged

**TYPE** High heat resistant stainless steel alloy with low Nickel content for SAW welding.

**APPLICATIONS** \* Cap layers for joining refractory Cr-Al-Si steels. \* Cladding corrosion resistant overlays. \* Cladding heat resistant overlays up to 1150°C. \* Cladding components in a sulphurous environment.

**PROPERTIES** The weld deposit shows excellent resistance against abrasion at elevated temperatures and can be easily machined. SACW 4820 should be welded with **FL 838** subarc flux.

**CLASSIFICATION**

AWS	A 5.22: ~T 327
EN ISO	17633: ~T 25 4
DIN: W.Nr.	1.4820

SUITABLE FOR	W.Nr:	EN ASTM/ACI	W.Nr:	EN ASTM/ACI
	1.4710	G-X30CrSi6	1.4724	X10CrAl13 TP405-CA15
	1.4745	G-X40CrSi23 TP433	1.4820	G-X12 CrSi 26 5
	1.4712	X10CrSi6 502	1.4729	G-X40CrSi13
	1.4762	X10CrAl24 TP443	1.4821	X20 CrNiSi 25 4 TP329
	1.4713	X10CrAl7 502	1.4740	G-X40CrSi17
	1.4773	X8Cr30	1.4822	G-X40CrNi 25 4 TP329
	1.4722	X10CrSi13	1.4742	X10CrAl18 430B-TP430
	1.4776	G-X40CrSi29	1.4823	G-X40CrNiSi 27 4 TP329HC

**APPROVALS** CE approved

**WELDING POSITIONS:**



**TYPICAL DEPOSIT WEIGHT %**

C	Mn	Si	Cr	Ni	P	S
0.07	0.70	0.4	25.00	4.00	<0.025	<0.025

**MECHANICAL PROPERTIES**

Shielding flux EN 14174	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	
FL 838	570	750	20	40			

**WELDING PARAMETERS / PACKING**

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A) DC+	spool type	kg / spool / Drum	kg / pallet
3.2	28-32	325-550	S-760	25 / 250	1000

**REDRYING TEMPERATURE** Usually not required