



# CEWELD AA 4820

**TYPE** High-alloyed tubular wire for heat resistant Steel. (Typ 25 4, 1.4820),

**APPLICATIONS** CEWELD AA 4820 is for welding cap layers for joining refractory Cr-Al-Si steels. Cladding corrosion resistant overlays. Cladding heat resistant overlays up to 1100°C. 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. When welding, care should be taken to minimize the heat input, because materials of this composition have a tendency to embrittle in the temperature range of approx. 600-800° C. The interpass temperature should not exceed 300° C. Therefore, the interpass temperature should not exceed 300°C.

**CLASSIFICATION** EN ISO 17633-A: TZ 25 4 M M21 1  
W.Nr. 1.4820  
FM 5

**SUITABLE FOR** 1.4340, 1.4710, 1.4745, 1.4746, 1.4712, 1.4762, 1.4713, 1.4773, 1.4722, 1.4776, 1.4724, 1.4820, 1.4729, 1.4821, 1.4740, 1.4822, 1.4742, 1.4823  
GX40CrNi27-4, G-X30CrSi6, G-X40CrSi23, X10CrSi6 502, X10CrAl24, X10CrAl7, X8Cr30, X10CrSi13, G-X40CrSi29, X8CrTi25, X10CrAl13, G-X12 CrSi 26 5, G-X40CrSi13, X20 CrNiSi 25 4, G-X40CrSi17, G-X40CrNi 25 4, X10CrAl18, G-X40CrNiSi 27 4, AISI 327, 442, 446, ASTM A 297 HC  
UNS S44200, 44600, J92605, J93005, J92605

**APPROVALS**

**WELDING POSITIONS**



**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

C	Si	Mn	Cr	Ni	Mo
0.08	1	0.7	25	4.6	0.25

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0.2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Hardness
As Welded	>450	>650	>15	94 HB

**REDRYING** Not required

**GAS ACC. EN ISO 14175** M21



# CEWELD AA 4820

AA 4820 1,6MM

Packaging	KG/unit	EanCode
BS-300	15	8720663415875
Drum	250	8720663415882