



CEWELD 4539 Ti

TYPE	Rutile basic electrode for welding Cr-Ni-Mo-Cu steels with very low C-content.								
APPLICATIONS	CEWELD® 4539 Ti is designed for joining exceptional corrosion resistant CrNiMoCu- steels at temperatures to 350 °C. Used in highly corrosive environments encountered in e.g. sulfur and phosphorus production, pulp & paper industry, fl ue gas desulfurization plants; desalination plants, fertilizer production and petrochemical industry; acetic and formic acid production, in pickling plants as well as heat exchangers and power plants using brackish or seawater.								
PROPERTIES	The weld deposit from CEWELD® 4539 Ti offers excellent corrosion resistance especially against Phosphor acid. The weld deposit is capable of taking a high polish								
CLASSIFICATION	AWS	A 5.4: E 385-26							
	EN ISO	3581-A: E 20 25 5 Cu L R 32							
	W.Nr.	1.4539							
	F-nr	5							
	FM	5							
SUITABLE FOR	1.4539 / 904L CrNiMoCu / 20 25 5 Cu L 1.4465, 1.4500, 1.4505, 1.4506, 1.4519, 1.4531, 1.4536, 1.4537, 1.4538, 1.4539, 1.4573, 1.4585, 1.4586 X1CrNiMoN25-25-2, X1NiCrMoCu 25-20-5, X1CrNiMoCuN 25-25-5, X2NiCrMoCuN25-20-5, X2NiCrMoCuN20-18, X4NiCrMoCuNb 20-18-2, X5NiCrMoCuTi20-18, X5NiCrMoCuNb22-18 ASTM A182, UNS N08904, S31726 Uranus B6, AISI 904L, Z2NCDU25-20,								
APPROVALS	CE								
WELDING POSITIONS									
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	P	S	Cr	Ni	Mo	Cu
	0.02	0.7	2	0.02	0.1	20.5	25	5	1.8
MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness	
					RT				
	As Welded	410	600	30	40			HRc	
REDRYING	300°C / 2 hr								
GAS ACC. EN ISO 14175									



CEWELD 4539 Ti

4539 Ti 2,5 X 300MM

Packaging	KG/unit	EanCode
Can	2,8	8720663413215

4539 Ti 3,2 X 350MM

Packaging	KG/unit	EanCode
Can	3,0	8720663413222

4539 Ti 4,0 X 350MM

Packaging	KG/unit	EanCode
Can	3,0	8720663413239