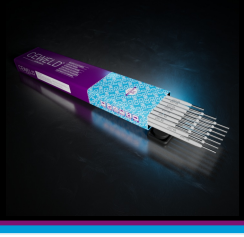


CEWELD 4501 Kb

certilas® THE FILLER METAL SPECIALIST

TYPE

Basic core wire alloyed electrode for welding Super Duplex

APPLICATIONS

Welding wrought, forged or cast super duplex stainless steels for service in the as-welded condition. Heterogeneous welding between super duplex stainless steels and dissimilar welds between other stainless and mild or low alloyed steels.

PROPERTIES

CEWELD® 4501 Kb is a basic coated electrode with a fully alloyed core, the duplex weld deposit provides exellent resistant to pitting, chloride stress corrosion cracking and intercrystalline corrosion due to the high CrMo(N) content (Pitting index >40). Furthermore, the weld metal alloy is saltwater-proof and offers high tensile strength, as a result of nitrogen being added to the alloy.

CLASSIFICATION

AWS	A 5.4: E 2595-15
EN ISO	3581-A: E 25 9 4 N L
W.Nr.	1.4501
F-nr	5
FM	5

SUITABLE FOR

UNS S32550 :UR 52 N, Ferralium 255, UNS S32520 :UR 52 N+, UNS S32750 :SAF 2507, UR 47 N+, UNS S32760 :ZERON 100, UNS 32760, UR 76 N, SM22Cr, SAF 2507, ASTM S32760 (ZERON 100), S32550 and S31260., It can also be used for welding duplex type 2205, 1.4460, 1.4462,1.4463,1.4515, 1.4517, 1.4507 URANUS 52N, SAF 25.07, GX 3 CrNiMoCuN 26-6-3, (1.4515), GX 3 CrNiMoCuN 26-6-3-3, (1.4517), 25% Cr Super Duplex steels SAF 25/07, S32750 1.4410 - 25Cr-7Ni-4Mo-0.28N SAF2507, NAS74N, S32760 1.4501 - 25Cr-7Ni-3.8Mo-0.7Cu-0.7W-0.25N, S32506 - SUS329J4L 25Cr-7Ni-3Mo-0.15N-0.2W NAS64 1.4507, S31803, S32205,

APPROVALS

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Cr	Ni	Mo	N	W	Cu
0.036	0.84	0.83	26.15	9.46	3.73	0.21	0.67	0.63

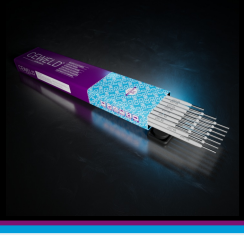
MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V	Hardness
				RT	
As Welded	560	730	23	50	HRc

REDRYING

300°C / 2 hr

GAS ACC. EN ISO 14175



CEWELD 4501 Kb

4501 KB 2,5 X 300MM

Packaging	KG/unit	EanCode
Can	2,5	8720663424341