



# CEWELD 4460 Cu

**TYPE** Rutile-Basic stainless steel electrode with extreme high corrosion resistance and mechanical properties.

**TOEPASSINGEN** 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

**EIGENSCHAPPEN** Higher corrosion resistance than standard Duplex steels with also higher mechanical properties due to the addition of Nitrogen.

**CLASSIFICATIE**

AWS	A 5.4: E 2593-16
EN ISO	3581-A: E 25 9 4 N L
W.Nr.	1.4501
F-nr	4
FM	5

**GESCHIKT VOOR** **welding Super Duplex 2593**  
 1.4410, 1.4460, 1.4467, 1.4468, 1.4501, 1.4507, 1.4515, 1.4517  
 X2CrNiMoN25-7-4, X2CrMnNiMoN26-5-4, GX2CrNiMoN25-6-3, X2CrNiMoCuWN25-7-4,  
 X2CrNiMoCuN25-6-3, GX2CrNiMoCuN26-6-3, GX2CrNiMoCuN25-6-3-3  
**UNS** S32750, S32760, J93380, S32520, S32550, S39274, S32950  
**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,  
 Ferralium 255, Super Duplex steels, ZERON 100

**GOEDKEURINGEN** CE

**LASPOSITIES**



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

C	Si	Mn	P	S	Cr	Ni	Mo	N	W	Cu
0.02	0.8	1.1	0.02	0.015	26	9.5	3.5	0.2	0.6	0.8

**MECHANISCHE WAARDEN**

Heat Treatment	R <sub>P0.2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness
				RT		
As Welded	560	760	20	50		HRC

**HERDROGEN** Not required

**GAS ACC. EN ISO 14175**



# CEWELD 4460 Cu

4460 CU 2,5 X 300MM

Packaging	KG/unit	EanCode
Can	2,5	8720663413185

4460 CU 3,2 X 350MM

Packaging	KG/unit	EanCode
Can	2,6	8720663413192

4460 CU 4,0 X 350MM

Packaging	KG/unit	EanCode
Can	2,8	8720663413208