



CEWELD 4842 Ti

TYPE Rutile coated electrode for heat resistant stainless steels

APPLICATIONS Common applications include industrial furnaces, annealing chambers, fused salt treatment installations and boiler parts, as well as heat exchangers..

PROPERTIES For welding heat-resistant austenitic steels of the 25% Cr, 20% Ni types. CEWELD 4842 Ti has good general oxidation resistance, especially at high temperatures, due to its high Cr content. The alloy is fully austenitic and is therefore sensitive to hot cracking. The temperature limits for use under intermittent oxidation depend on cycle frequency. In general the alloy is heat resistant up to 1200 °C. This alloy can withstand relatively severe thermic shock, and is superior to type 309 L.

CLASSIFICATION	AWS	A 5.4: E 310-16
	EN ISO	3581-A: E 25 20 R 32
	F-nr	5
	FM	5
	W.Nr.	~1.4842

SUITABLE FOR 1.4823, 1.4826, 1.4828, 1.4832, 1.4840, 1.4841, 1.4846, 1.4848, 1.4837, 1.4710, 1.4713, 1.4724, 1.4726, 1.4742, 1.4745, 1.4762, 1.4845, 1.4740
 X15CrNiSi25-21, X8CrNi25-21, X15CrNiSi20-12, GX15CrNi25-20, X40CrNi25-21, GX40CrNiSi22-10, X10CrAlSi7, X10CrAlSi13, X10CrAlSi18, X10CrAlSi25, GX30CrSi7, GX40CrSi17
 AISI 305, 310, 314, ASTM A297 HF, A297 HJ

APPROVALS No Approvals Found

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	P	S	Cr	Ni	Fe
	0.1	0.6	2	0.02	0.015	26	21	Rem.

ALL WELD MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2}	R _m	A ₅	Impact Energy (J) ISO-V
	As Welded /	MPa	MPa	(%)	RT
		380	600	30	75

REDRYING TEMPERATURE 300°C / 2 hr

GAS ACCORDING EN 14175



CEWELD 4842 Ti

4842 TI 2,0 X 300MM

Type	KG/unit	EANCode
Can	2,6	8720663415752

4842 TI 2,5 X 300MM

Type	KG/unit	EANCode
Can	2,5	8720663415769

4842 TI 3,2 X 350MM

Type	KG/unit	EANCode
Can	2,8	8720663415783

4842 TI 4,0 X 350MM

Type	KG/unit	EANCode
Can	3,0	8720663415790

4842 TI 5,0 X 350MM

Type	KG/unit	EANCode
Can	2,5	8720663415806