

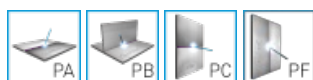


# CEWELD 4850 Kb

|                |                                                                                                                                                                                   |
|----------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| TYPE           | Basic electrode for heat resistant stainless steel SMAW welding                                                                                                                   |
| APPLICATIONS   | CEWELD® 4850 Kb for repair and build-up welding of same and similar types of heat-resistant steels and cast steels.                                                               |
| PROPERTIES     | CEWELD® 4850 Kb has high corrosion resistance and excellent weldability for both AC and DC+. The weld metal can be used up to 1050 °C in carburized and low-sulphur environments. |
| CLASSIFICATION | EN ISO 3581-A: E Z 21 33 Nb B 32<br>W.Nr. ~1.4850<br>FM 5                                                                                                                         |
| SUITABLE FOR   | 1.4876, 1.4861, 1.4859, 1.4958, 1.4959,<br>G-X10NiCrNb 32 20, X10NiCrAlTi 32 20, X5NiCrAlTi 31 20, X8NiCrAlTi 31 21,<br>UNS N 08800, N 08810, N 08811, Alloy 800H                 |

APPROVALS CE

WELDING POSITIONS



TYPICAL CHEMICAL  
ANALYSIS OF WELD METAL  
(%)

| C    | Si  | Mn  | P    | S    | Cr | Ni |
|------|-----|-----|------|------|----|----|
| 0.15 | 0.5 | 4.5 | 0.02 | 0.01 | 22 | 34 |

MECHANICAL PROPERTIES

| Heat<br>Treatment | R <sub>P0.2</sub><br>(MPa) | R <sub>m</sub><br>(MPa) | A <sub>5</sub><br>(%) | Impact Energy (J) ISO-V | Hardness |
|-------------------|----------------------------|-------------------------|-----------------------|-------------------------|----------|
|                   |                            |                         |                       | RT                      |          |
| As Welded         | 380                        | 600                     | 25                    | 50                      | HRC      |

REDRYING 300°C / 2 hr

GAS ACC. EN ISO 14175



# CEWELD 4850 Kb

4850 KB 2,5 X 350MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Can       | 2,8     | 8720663415813 |