



# CEWELD SACW 4820 (1.4820)



|                                                        |                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |        |     |    |    |
|--------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------|-----|----|----|
| TYPE                                                   | High heat resistant stainless steel alloy with low Nickel content for SAW welding.                                                                                                                                                                                                                                                                                                                                                                                          |        |     |    |    |
| APPLICATIONS                                           | Cap layers for joining refractory Cr-Al-Si steels. Cladding corrosion resistant overlays. Cladding heat resistant overlays up to 1150°C. Cladding components in a sulphurous environment.                                                                                                                                                                                                                                                                                   |        |     |    |    |
| PROPRIÉTÉS                                             | The weld deposit shows excelent resistance against abrasion at elevated temperatures and can be easely machined. CEWELD® SACW 4820 should be welded with CEWELD® FL 838 SAW flux.                                                                                                                                                                                                                                                                                           |        |     |    |    |
| CLASSIFICATION                                         | W.Nr.                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | 1.4820 |     |    |    |
| CONVIENT POUR                                          | 1.4340, 1.4710, 1.4745, 1.4746, 1.4712, 1.4762, 1.4713, 1.4773, 1.4722, 1.4776, 1.4724, 1.4820, 1.4729, 1.4821, 1.4740, 1.4822, 1.4742, 1.4823<br>GX40CrNi27-4, G-X30CrSi6, G-X40CrSi23, X10CrSi6 502, X10CrAl24, X10CrAl7, X8Cr30, X10CrSi13, G-X40CrSi29, X8CrTi25, X10CrAl13, G-X12 CrSi 26 5, G-X40CrSi13, X20 CrNiSi 25 4, G-X40CrSi17, G-X40CrNi 25 4, X10CrAl18, G-X40CrNiSi 27 4,<br>AISI 327, 442, 446, ASTM A 297 HC<br>UNS S44200, 44600, J92605, J93005, J92605 |        |     |    |    |
| AGRÉMENTS                                              |                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |        |     |    |    |
| POSITIONS DE SOUDAGE                                   |                                                                                                                                                                                                                                                                                                                                                                                            |        |     |    |    |
| ANALYSE CHIMIQUE<br>TYPIQUE DU MÉTAL DE<br>SOUDURE (%) | C                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | Mn     | Si  | Cr | Ni |
|                                                        | 0.07                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | 0.7    | 0.4 | 25 | 4  |
| PROPRIÉTÉS MÉCANIQUES                                  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |        |     |    |    |
| ETUVAGE                                                | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                |        |     |    |    |
| GAS ACC. EN ISO 14175                                  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |        |     |    |    |



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|                          |           |         |               |
|--------------------------|-----------|---------|---------------|
| SACW 4820 (1.4820) 3,2MM | Packaging | KG/unit | EanCode       |
|                          | S-760     | 248     | 8720663415936 |