



CEWELD 4842 Ti

TYPE	Rutile-coated stick electrode for heat-resistant stainless steels. (Type 25 20, 310)							
APPLICATIONS	CEWELD® 4842 Ti is for the dissimilar welding of heat-resistant rolled, forged and cast steels. Common applications include industrial furnaces, annealing chambers, systems for treating molten salts and boiler parts as well as heat exchangers.							
PROPERTIES	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 12						
	W.Nr.	~1.4842						
	F-nr	5						
	FM	5						
SUITABLE FOR	ISO 15608: 8.1 Austenitic ≤ 19 % Cr , TÜV 1000: Gr. 21-30, Type: 25% Cr, 22%Ni 1.4710, 1.4713, 1.4724, 1.4726, 1.4742, 1.4745, 1.4762, 1.4823, 1.4826, 1.4828, 1.4832, 1.4835,1.4837, 1.4840, 1.4841, 1.4845, 1.4846, 1.4848, 1.4849, 253MA, X15CrNiSi 25 20, G-X40CrNiSi 25 12, G-X15CrNi 25 20, X8CrNi25-21, GX40CrNiSi22-10, X15CrNiSi20-12, 310, 310S, CK20, 305, 314, 725LN, 316L ASTM A297 HF / A297HJ UNS: S31000, S31008, S31050, S31603							
APPROVALS								
WELDING POSITIONS	PAPBPCPDPEPF							
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.
MECHANICAL PROPERTIES	Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness	
					RT			
	As Welded	380	600	30	75		HRc	
REDRYING	300°C / 2 hr							
GAS ACC. EN ISO 14175								



CEWELD 4842 Ti

4842 Ti 2,0 X 300MM

Packaging	KG/unit	EanCode
Can	2,6	8720663415752

4842 Ti 2,5 X 300MM

Packaging	KG/unit	EanCode
Can	2,5	8720663415769

4842 Ti 3,2 X 350MM

Packaging	KG/unit	EanCode
Can	2,8	8720663415783

4842 Ti 4,0 X 350MM

Packaging	KG/unit	EanCode
Can	3,0	8720663415790

4842 Ti 5,0 X 350MM

Packaging	KG/unit	EanCode
Can	2,5	8720663415806