



CEWELD E Alloy 22H

TYPE Basic coated special electrode for high temperature cast steel.

APPLICATIONS CEWELD[®] E Alloy 22H is used for joining and build-up welding on identical or similar high-alloy 0,5%C-28%Cr- 50%Ni-5%W high-temperature cast materials, e.g. M.no. 2.4879 (G-NiCr28W). The main application is centrifugally cast pipes for furnaces in the petrochemical industry with operating temperatures up to 1150°C. Furnace parts, sintering and calcining muffles, cement kiln components resistant to hot abrasion, radiant tubes and pyrolysis coils.

PROPERTIES CEWELD E Alloy 22H is characterized by a quiet and stable arc. Good slag removability and fine flaky seam pattern. The weld metal is high-temperature resistant with very good creep resistance. High nickel gives the alloy good resistance to carburisation and under oxidising conditions high chromium provides useful resistance to sulphidation

CLASSIFICATION DIN 1736: EL-NiCr28W (mod)
W.Nr. 2.4879

SUITABLE FOR 2.4879
G NiCr28W, G-X45NiCrWSi 48 28
Duraloy 22H, Duraloy Super 22H (+2%Co), Paralloy H48T, Centralloy 4879, Marker G4879, Pyrotherm G 28/48/5W, Cronite HR23, Lloyds T75, Thermax 70, Manaurite 50W, Thermalloy T75

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Cr	Ni	W	Fe
0.5	0.8	1.2	29	50	4.5	14

MECHANICAL PROPERTIES

Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness
As Welded	480	650	5	270 HV

REDRYING 300°C / 2 hr

WELDING RECOMMENDATION Clean the welding area. Weld electrodes with short stick out, vertical electrode guidance and using the line bead technique. Select low amperage and oscillate only slightly. Interpass temperature max. 150°C.

GAS ACC. EN ISO 14175