



# 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  
W.Nr. ~1.4850  
FM 5

**SUITABLE FOR** 1.4876, 1.4861, 1.4859, 1.4958, 1.4959,  
G-X10NiCrNb 32 20, X10NiCrAlTi 32 20, X5NiCrAlTi 31 20, X8NiCrAlTi 31 21,  
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 Treatment | R <sub>P0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | 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 |