



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 1.4823, 1.4826, 1.4828, 1.4832, 1.4840, 1.4841, 1.4846, 1.4848, 1.4837, 1.4710, 1.4713, 1.4724, 1.4726, 1.4742, 1.4745, 1.4762, 1.4845, 1.4740
 X15CrNiSi25-21, X8CrNi25-21, X15CrNiSi20-12, GX15CrNi25-20, X40CrNi25-21, GX40CrNiSi22-10, X10CrAlSi7, X10CrAlSi13, X10CrAlSi18, X10CrAlSi25, GX30CrSi7, GX40CrSi17
 AISI 305, 310, 314, ASTM A297 HF, A297 HJ

APPROVALS

WELDING POSITIONS



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 |