



# CEWELD 4460 Cu

**TYPE** Rutile-Basic stainless steel electrode with extreme high corrosion resistance and mechanical properties.

**APPLICATIONS** CEWELD® 4460 Cu is for welding super duplex stainless steels. Same type welding between super duplex stainless steels and between other stainless and unalloyed or low alloy steels. CEWELD® 4460 Cu is used wherever a combination of good corrosion resistance and high strength is required.

**PROPERTIES** CEWELD® 4460 Cu has an austenitic-ferritic microstructure for surfacing and joint welding on super duplex steels. Application temperature ≤ 250 C°

<b>CLASSIFICATION</b>	AWS	A 5.4: E 2593-16
	EN ISO	3581-A: E 25 9 4 N L
	W.Nr.	1.4501
	F-nr	4
	FM	5

**SUITABLE FOR** **welding Super Duplex 2593**  
 1.4410, 1.4460, 1.4467, 1.4468, 1.4501, 1.4507, 1.4515, 1.4517  
 X2CrNiMoN25-7-4, X2CrMnNiMoN26-5-4, GX2CrNiMoN25-6-3, X2CrNiMoCuWN25-7-4,  
 X2CrNiMoCuN25-6-3, GX2CrNiMoCuN26-6-3, GX2CrNiMoCuN25-6-3-3  
**UNS** S32750, S32760, J93380, S32520, S32550, S39274, S32950  
**SAF** 25/07, S32750 1.4410 - 25Cr-7Ni-4Mo-0.28N SAF2507, NAS74N, S32760 1.4501 - 25Cr-7Ni-3.8Mo-0.7Cu-0.7W-0.25N, S32506 - SUS329J4L 25Cr-7Ni-3Mo-0.15N-0.2W NAS64 1.4507, S31803, S32205,  
 Ferralium 255, Super Duplex steels, ZERON 100

**APPROVALS** CE



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	P	S	Cr	Ni	Mo	N	W	Cu
	0.02	0.8	1.1	0.02	0.015	26	9.5	3.5	0.2	0.6	0.8

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	560	760	20	50		HRC

**REDRYING** 300°C / 2 hr

**GAS ACC.** EN ISO 14175



# CEWELD 4460 Cu

4460 CU 2,5 X 300MM

Packaging	KG/unit	EanCode
Can	2,5	8720663413185

4460 CU 3,2 X 350MM

Packaging	KG/unit	EanCode
Can	2,6	8720663413192

4460 CU 4,0 X 350MM

Packaging	KG/unit	EanCode
Can	2,8	8720663413208