



CEWELD 4460 Cu

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

APPLICATIONS Welding wrought, forged or cast super duplex stainless steels for service in the as-welded condition. Heterogeneous welding between super duplex stainless steels and dissimilar welds between other stainless and mild or low alloyed steels

PROPRIÉTÉS Higher corrosion resistance than standard Duplex steels with also higher mechanical properties due to the addition of Nitrogen.

CLASSIFICATION

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

CONVIENT POUR **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

AGRÉMENTS CE

POSITIONS DE SOUDAGE



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

PROPRIÉTÉS MÉCANIQUES

Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
				RT		
As Welded	560	760	20	50		HRC

ETUVAGE Not required

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