



CEWELD 4853 Kb

TYPE	Basic electrode for heat resistant stainless steel SMAW welding.						
APPLICATIONS	CEWELD® 4853 Kb is designed for joining and hardfacing high-temperature CrNi steels of the same or similar types and cast steels in low-sulphur environments.						
PROPERTIES	CEWELD® 4853 Kb is characterized by high corrosion resistance and excellent weldability for both AC and DC+. The weld metal is scale resistant up to 1050 °C.						
CLASSIFICATION	EN ISO	3581-A: E Z 25 35 Nb B 32					
	W.Nr.	1.4853					
	FM	5					
SUITABLE FOR	(1.4806), 1.4837, 1.4848, 1.4849, 1.4852, 1.4853, 1.4857, G-X 40 NiCrNb 35 25, G-X 40 NiCrSi 35 25, G-X40CrNiSi25-12, G-X40CrNiSi25--20, G-X40NiCr38-18, G-X40NiCrNb35-25, HK40, HK45, UNS: J93503, J94204, N08705 J 94013, J 94003, J 93633, J 93513, J 93503, J 94224, J 94204, J 94203, N 08005, N 08004, N 08705						
APPROVALS	CE						
WELDING POSITIONS	 PA  PB  PC  PF						
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	P	S	Cr	Ni
	0.4	0.9	1	0.025	0.015	26	35
MECHANICAL PROPERTIES	Heat Treatment		R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness	
	As Welded		500	700	10	HRc	
REDRYING	300°C / 2 hr						
GAS ACC. EN ISO 14175							



CEWELD 4853 Kb

4853 KB 3,2 X 350MM

Packaging	KG/unit	EanCode
Can	2,8	8720663415820

4853 KB 4,0 X 350MM

Packaging	KG/unit	EanCode
Can	3,0	8720663424518