



# CEWELD 4853 Kb

**TYPE** Basic electrode for heat resistant stainless steel SMAW welding.

**APPLICATIONS** Joining and cladding high heat resistant CrNi-steels of the same kind and Cast steels in a low sulphurous environment.

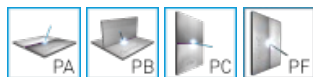
**PROPERTIES** High corrosion resistance and excellent weldability on both AC and DC+. The weld deposit is scale resistant up to 1050 °C

**CLASSIFICATION** EN ISO 3581-A: E Z 25 35 Nb B 32  
W.Nr. 1.4853  
FM 5

**SUITABLE FOR** 1.4837, 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**



**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 <sub>p0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	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