



# CEWELD 4430 Ti

**TYPE** Stainless steel 316L stick electrode for SMAW welding Cr-Ni-Mo steels with very low C-content. (19 12 3 L,V4A)

**APPLICATIONS** CEWELD 4430 Ti is suitable for welding corrosion-resistant Cr-Ni-Mo steels with extremely low C-content at working temperatures up to 350 °C.

**PROPERTIES** The CEWELD 4430-Ti weld deposit is scale-resistant up to 800 °C in normal atmosphere and oxidizing gases. Working temperatures up to 400 °C. Extreme stable arc on both AC and DC+ with no spatter losses. The weld deposit is capable of taking a high polish. TÜV-approval down to -120°C (> 32J).

**CLASSIFICATION**

AWS	A 5.4: E 316L-16
EN ISO	3581-A: E 19 12 3 LR 12
W.Nr.	1.4430
F-nr	4
FM	5

**SUITABLE FOR** **ISO 15608: 8.1 Austenit ≤ 19 % Cr , TÜV 1000: Gr. 21-30,**  
 1.4583, 1.4435, 1.4436, 1.4401, 1.4404, 1.4406, 1.4408, 1.4401, 1.4571, 1.4580, 1.4581, 1.4406, 1.4521, 1.4301, 1.4306,  
 X102CrNiMoNb 18 12, X2CrNiMo 18 14 3 (TP), X4CrNiMo 17 13 3, X2CrNiMo 17 12 2 (TP), X 5CrNiMo 19 11 2, X4CrNiMo 17 12 2 (TP), X6CrNiMo 17 12 2, X6CrNiMoNb 17 12 3, X2CrNiMoN 17 12 3 (TP), X2CrMoTi18-2, G-X5CrNiMoNb 19 11 12  
 316Cb, 316L, 316L, 316LN, 316H, 316, 316Ti, 316Cb, 316LN, 444  
 S31640, S31603, S31653, S31600, S31630, S44400

**APPROVALS** TÜV: 12537.00, CE

**WELDING POSITIONS**



**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

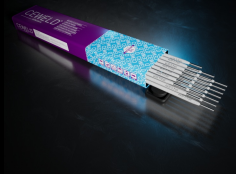
C	Si	Mn	P	S	Cr	Ni	Mo
0.025	0.85	0.8	0.02	0.015	18.5	12	2.5

**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	-110°C	
As Welded	460	600	38	70	60	HRC

**REDRYING** 300°C / 2 hr

**GAS ACC.** EN ISO 14175



# CEWELD 4430 Ti

4430 TI 1,6 X 250MM

Packaging	KG/unit	EanCode
Can	2,0	8720663412973

4430 TI 2,0 X 300MM

Packaging	KG/unit	EanCode
Can	2,5	8720663412980

4430 TI 2,5 X 300MM

Packaging	KG/unit	EanCode
Can	2,5	8720663412997

4430 TI 3,2 X 350MM

Packaging	KG/unit	EanCode
Can	2,6	8720663413017

4430 TI 4,0 X 350MM

Packaging	KG/unit	EanCode
Can	2,8	8720663413031