



CEWELD 4332 Ti

TYPE	Rutile-basic coated electrode for welding stainless steels and dissimilar steels.(Type 309L, 23 12 L, 1.4332)							
APPLICATIONS	CEWELD® 4332 Ti is for joining heat resistant CrNi-steels of the same kind and also joining dissimilar metals such as steel to stainless steel. Cladding on low alloyed steels in case a 18/8 CrNi layer is required in the first layer. Scale resistant up to 1050 °C.							
PROPERTIES	CEWELD® 4332 Ti is a rutile basic electrode for joining heat resistant CrNi-steels of the same kind and also joining dissimilar metals such as steel to stainless steel.							
CLASSIFICATION	AWS	A 5.4: E 309L-16						
	EN ISO	3581-A: E 23 12 L R 32						
	W.Nr.	1.4332						
	F-nr	1						
	FM	5						
SUITABLE FOR	ISO 15608: 8.1 Austenit ≤ 19 % Cr , 23% Cr, 12%Ni Type 1.2780, 1.4541, 1.4550, 1.4710, 1.4712 , 1.4713, 1.4724, 1.4729, 1.4740, 1.4741, 1.4742, 1.4746, 1.4762, 1.4745, 1.4825, 1.4826, 1.4828, 1.4832, 1.4878 , X15CrNiSi20 12, G-X 40 CrNiSi20 9, AISI 446, AISI442, AISI309, UNS S30900, S44200, S44600							
APPROVALS	CE							
WELDING POSITIONS	     							
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	P	S	Cr	Ni	Fe
	0.02	0.5	1	0.02	0.015	24	13	Rem.
MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness	
					RT			
	As Welded	400	550	30	55		HRc	
REDRYING	300°C / 2 hr							
CURRENT TYPE	AC / DC+							
GAS ACC. EN ISO 14175								



CEWELD 4332 Ti

4332 Ti 2,0 X 300MM

Packaging	KG/unit	EanCode
Can	2,4	8720663415578

4332 Ti 2,5 X 300MM

Packaging	KG/unit	EanCode
Can	2,4	8720663415585

4332 Ti 3,2 X 350MM

Packaging	KG/unit	EanCode
Can	2,8	8720663415592

4332 Ti 4,0 X 350MM

Packaging	KG/unit	EanCode
Can	2,8	8720663415615

4332 Ti 5,0 X 450MM

Packaging	KG/unit	EanCode
Can	3,2	8720663415622