



CEWELD 4430 H

TYPE Rutile basic electrode for Cr-Ni-Mo steels with increased Si -content(Type 4430/ V4A)

APPLICATIONS CEWELD® 4430 H is suitable for welding corrosion-resistant Cr-Ni-Mo steels for working temperatures up to 400 °C.

PROPERTIES The weld deposit of the CEWELD® 4430 H has higher temperature scale-resistance then standard AISI 316.

CLASSIFICATION

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

SUITABLE FOR **ISO 15608: 8.1 Austenit ≤ 19 % Cr , TÜV 1000: Gr. 21, 22, 24,**
 1.4401, 1.4404 , 1.4409 , 1.4429, 1.4432, 1.4435, 1.4436, 1.4571, 1.4580, 1.4583, 1.4919
 X5CrNiMo17-12-2, X2CrNiMo17-12-2, GX2CrNiMo19-11-2, X2CrNiMoN17-12-3, X2CrNiMo17-12-3,
 X2CrNiMo18-14-3, X3CrNiMo17-12-3, X6CrNiMoTi17-12-2, X6CrNiMoNb17-12-2, X10CrNiMoNb18-12,
 X6CrNiMoB17-12-2,
 UNS S31600, S31603, S31635, S31640, S31653, S31609
 AISI 316L, 316Ti, 316Cb, 347, 347H, 321, 321H, CF10M, BS 316S51, 316S52, 316S53, 316C16,
 316C71, 316H

APPROVALS CE

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Cr	Ni	Mo
0.04	0.9	1	19	12	2.8

MECHANICAL PROPERTIES

Heat Treatment	Rp0,2 (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness
				RT		
As Welded	350	600	35	70		HRc

REDRYING 300°C / 2 hr

GAS ACC. EN ISO 14175