



CEWELD 4316 H

TYPE Welding electrode for AISI 304H types Cr-Ni steel. (Type 308H, 1.4302, 19 9)

APPLICATIONS CEWELD® 4316 H is suitable for welding un-stabilized austenitic stainless steel with low carbon content, suitable for working temperatures up to 730 °C.

PROPERTIES Compare to the standard CEWELD® 4316 Ti the weld deposit has much higher temperature scale-resistance up to 800 °C due to the increased silicon content.

CLASSIFICATION

| | |
|--------|-----------------------|
| AWS | A 5.4: E 308H-16 |
| EN ISO | 3581-A: E 19 9 H R 12 |
| W.Nr. | 1.4302 |
| F-nr | 4 |
| FM | 5 |

SUITABLE FOR **ISO 15608: 8.1 Austenitic ≤ 19 % Cr , TÜV 1000: Gr. 21, 9 % Ni,**
 1.4301, 1.4308, 1.6900, 1.6901, 1.6902, 1.6903, 1.9606
 X 5 CrNi 18 10, X 5 CrNi 18 9, G-X 6 CrNi 18 9, X 12 CrNi 18 9, G-X 8 CrNi 18 10, X 6 CrNi 18 10, X 10 CrNiTi 18 10, X 5 CrNi 18 10
 AISI 304, 304H, 308, 308H, 321, 321H, 347, 347H,
 UNS S30409, S32109, S34709, S30400, S32100, S34700

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

| C | Si | Mn | P | S | Cr | Ni | Mo |
|------|-----|-----|------|------|----|----|-----|
| 0.05 | 0.5 | 1.1 | 0.02 | 0.01 | 20 | 10 | 0.2 |

MECHANICAL PROPERTIES

| Heat Treatment | R _{P0.2} (MPa) | R _m (MPa) | A ₅ (%) | Impact Energy (J) ISO-V | | Hardness |
|----------------|-------------------------|----------------------|--------------------|-------------------------|--|----------|
| | | | | RT | | |
| As Welded | 360 | 610 | 40 | 70 | | HRc |

REDRYING 300°C / 2 hr

GAS ACC. EN ISO 14175



CEWELD 4316 H

4316 H 3,2 X 350MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| Can | 2,8 | 8720663411570 |

4316 H 4,0 X 450MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| Can | 2,8 | 8720663411587 |