
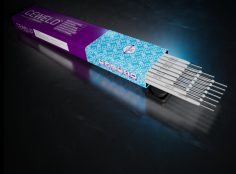




# CEWELD 4440 AC

TYPE	Rutile basic Austenitic, non magnetic stainless steel electrode																	
APPLICATIONS	CEWELD® 4440 AC made for welding stabilized and un-stabilized CrNiMo(N) type of steels with high corrosion resistance. Also suitable for dissimilar welds between steel and stainless steel or dissimilar stainless steels. Mainly used in chemical, paper and cotton industry																	
PROPERTIES	CEWELD® 4440 AC have high mechanical properties and excellent weldability, corrosion resistance is better than AISI 316 due to the high Mo. content. Suitable for use up to 400 °C. The weld deposit is non magnetic.																	
CLASSIFICATION	AWS	A 5.4: E ~317L-17																
	EN ISO	3581-A: E 18 16 5 L R 32																
	F-nr	4																
	FM	5																
	W.Nr.	1.4440																
SUITABLE FOR	Designed for joining corrosion resistant CrNiMoN steel as well as for austenitic-ferritic joints. <b>ISO 15608: 8.1 Austenitic ≤ 19 % Cr , TÜV 1000: Gr. 26, 27, 28</b> 1.4429, 1.4434, 1.4435, 1.4436, 1.4438, 1.4439, 1.4453, 1.4583, X2CrNiMoN 17 13 5, X2CrNiMoN 17 13 3, X2CrNiMo 18 15 4, X10CrNiMoNb 18 12, X2CrNiMoN17-13-3, X2CrNiMoN18-12-4, X2CrNiMo18-14-3, X3CrNiMnMoN19-16 UNS S31600, S31653, S31703, S31726, S31753 AISI 316Cb, 316L, 316LN, 317L, 317LN, 317LMN																	
APPROVALS	No Approvals Found																	
WELDING POSITIONS																		
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> </tr> </thead> <tbody> <tr> <td>0.03</td> <td>0.8</td> <td>1.1</td> <td>0.02</td> <td>0.015</td> <td>19</td> <td>13</td> <td>3.8</td> </tr> </tbody> </table>		C	Si	Mn	P	S	Cr	Ni	Mo	0.03	0.8	1.1	0.02	0.015	19	13	3.8
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ALL WELD MECHANICAL PROPERTIES	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th>Heat Treatment</th> <th>R<sub>p0,2</sub> MPa</th> <th>R<sub>m</sub> MPa</th> <th>A<sub>5</sub> (%)</th> <th>Impact Energy (J) ISO-V RT</th> </tr> </thead> <tbody> <tr> <td>As Welded /</td> <td>400</td> <td>580</td> <td>32</td> <td>70</td> </tr> </tbody> </table>		Heat Treatment	R <sub>p0,2</sub> MPa	R <sub>m</sub> MPa	A <sub>5</sub> (%)	Impact Energy (J) ISO-V RT	As Welded /	400	580	32	70						
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As Welded /	400	580	32	70														
REDRYING TEMPERATURE	300°C / 2 hr																	
GAS ACCORDING EN 14175																		



# CEWELD 4440 AC

4440 AC 2,5 X 300MM

Type	KG/unit	EANCode
Can	2,0	8720663413093

4440 AC 3,2 X 350MM

Type	KG/unit	EANCode
Can	2,5	8720663413109

4440 AC 4,0 X 350MM

Type	KG/unit	EANCode
Can	2,5	8720663413116