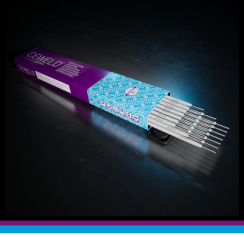


CEWELD 4316 H

certilas® THE FILLER METAL SPECIALIST

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
F-nr	4
FM	5
W.Nr.	1.4302

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

No Approvals Found

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

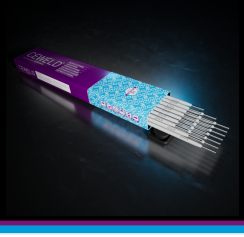
ALL WELD MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ MPa	Rm MPa	A5 (%)	Impact Energy (J) ISO-V RT
As Welded /	360	610	40	70

REDRYING TEMPERATURE

300°C / 2 hr

GAS ACCORDING EN 14175



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4316 H 3,2 X 350MM	Type	KG/unit	EANCode
	Can	2,8	8720663411570

4316 H 4,0 X 450MM	Type	KG/unit	EANCode
	Can	2,8	8720663411587