



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
F-nr	4
FM	5
W.Nr.	1.4430

SUITABLE FOR **ISO 15608: 8.1 Austenit ≤ 19 % Cr , TÜV 1000: Gr. 21, 22, 24,**
 1.4301, 1.4303, 1.4306, 1.4308, 1.4311, 1.4401, 1.4404, 1.4406, 1.4408, 1.4429, 1.4435, 1.4436, 1.4438, 1.4439, 1.4541, 1.4550, 1.4552, 1.4571, 1.4580, 1.4581, 1.4583, 1.4941, 1.4948, 1.4949, 1.4961, 1.6900, 1.6901, 1.6902, 1.6903
 X102CrNiMoNb 18 12, X2CrNiMo 18 14 3 (TP), X4CrNiMo 17 13 3, X2CrNiMo 17 12 2 (TP), X 5CrNiMo 19 11 2, X4CrNiMo 17 12 2 (TP), X6CrNiMo 17 12 2, X6CrNiMoNb 17 12 3, X2CrNiMoN 17 12 3 (TP), X2CrMoTi18-2
 316Cb, 316L, 316L, 316LN, 316H, 316, 316Ti, 316Cb, 316LN, 444
 S31640, S31603, S31653, S31600, S31630, S44400

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

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R _{P0,2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V RT
As Welded /	350	600	35	70

REDRYING TEMPERATURE 300°C / 2 hr

GAS ACCORDING EN 14175