



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,**
 1.4401, 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

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