



CEWELD 4316 Ti

TYPE Corrosion-resistant rutile-coated stick electrode for Cr-Ni steels with very low C content. (Type 308L, 19 9 L)

APPLICATIONS CEWELD 4316Ti is suitable for welding corrosion-resistant Cr-Ni steels with an extremely low C content at working temperatures of up to 350° C. Tank construction (e.g. wine tanks) and furnace construction

PROPERTIES The weld deposit is scale-resistant up to approx. 800°C in normal atmosphere and oxidizing gases. The weld deposit is capable of taking a high polish

CLASSIFICATION

| | |
|--------|-----------------------|
| AWS | A 5.4: E 308L-16 |
| EN ISO | 3581-A: E 19 9 L R 12 |
| F-nr | 4 |
| FM | 5 |
| W.Nr. | 1.4316 |

SUITABLE FOR **ISO 15608: 8.1 Austenitic ≤ 19 % Cr 9 % Ni, , TÜV 1000: Gr. 21 - 22 (29 max.350°C),**
 1.4301, 1.4306, 1.4307, 1.4308, 1.4311, 1.4312, 1.6900, 1.6901, 1.6902, 1.6903, 1.9606, 1.4541, 1.4546, 1.4550
 X 5 CrNi 18 10, X 2 CrNi 19 11, 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, 308L, 321, 321H, 347, 347H,
 UNS S30409, S32109, S34709, S30400, S32100, S34700

APPROVALS TÜV (12536.00) CE

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

| C | Si | Mn | P | S | Cr | Ni | Fe |
|------|------|----|-------|------|----|----|------|
| 0.02 | 0.75 | 1 | 0.015 | 0.01 | 19 | 10 | Rem. |

ALL WELD MECHANICAL PROPERTIES

| Heat Treatment | R _{p0,2} MPa | R _m MPa | A ₅ (%) | RT | Impact Energy (J) ISO-V |
|----------------|-----------------------|--------------------|--------------------|----|-------------------------|
| As Welded / | 400 | 600 | 38 | 70 | -196°C 40 |

REDRYING TEMPERATURE 300°C / 2 hr

GAS ACCORDING EN 14175



CEWELD 4316 Ti

4316 TI 1,6 X 250MM

| Type | KG/unit | EANCode |
|------|---------|---------------|
| Can | 2 | 8720663411594 |

4316 TI 2,0 X 300MM

| Type | KG/unit | EANCode |
|------|---------|---------------|
| Can | 2,4 | 8720663411600 |

4316 TI 2,5 X 300MM

| Type | KG/unit | EANCode |
|------|---------|---------------|
| Can | 2,5 | 8720663411617 |

4316 TI 3,2 X 350MM

| Type | KG/unit | EANCode |
|------|---------|---------------|
| Can | 2,8 | 8720663411624 |

4316 TI 4,0 X 350MM

| Type | KG/unit | EANCode |
|------|---------|---------------|
| Can | 2,8 | 8720663411648 |

4316 TI 5,0 X 450MM

| Type | KG/unit | EANCode |
|------|---------|---------------|
| Can | 3,2 | 8720663411655 |