



CEWELD 4430 Ti

TYPE Stainless steel 316L stick electrode for SMAW welding Cr-Ni-Mo steels with very low C-content. (19 12 3 L,V4A)

APPLICATIONS CEWELD® 4430 Ti is suitable for welding corrosion-resistant Cr-Ni-Mo steels with extremely low C-content at working temperatures up to 350 °C.

PROPERTIES The CEWELD® 4430-Ti weld deposit is scale-resistant up to 800 °C in normal atmosphere and oxidizing gases. Working temperatures up to 400 °C. Extreme stable arc on both AC and DC+ with no spatter losses. The weld deposit is capable of taking a high polish. TÜV-approval down to -120°C (> 32J).

CLASSIFICATION

AWS	A 5.4: E 316L-16
EN ISO	3581-A: E 19 12 3 LR 12
W.Nr.	1.4430
F-nr	4
FM	5

SUITABLE FOR **ISO 15608: 8.1 Austenitic ≤ 19 % Cr**
 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	P	S	Cr	Ni	Mo
0.025	0.85	0.8	0.02	0.015	18.5	12	2.5

MECHANICAL PROPERTIES

Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
				RT	-110°C	
As Welded	460	600	38	70	60	HRC

REDRYING 300°C / 2 hr

CURRENT TYPE AC / DC+

GAS ACC. EN ISO 14175



CEWELD 4430 Ti

4430 TI 1,6 X 250MM

Packaging	KG/unit	EanCode
Can	2,0	8720663412973

4430 TI 2,0 X 300MM

Packaging	KG/unit	EanCode
Can	2,5	8720663412980

4430 TI 2,5 X 300MM

Packaging	KG/unit	EanCode
Can	2,5	8720663412997

4430 TI 3,2 X 350MM

Packaging	KG/unit	EanCode
Can	2,6	8720663413017

4430 TI 4,0 X 350MM

Packaging	KG/unit	EanCode
Can	2,8	8720663413031