



# 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
W.Nr.	1.4316
F-nr	4
FM	5

**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.

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness
				RT	-196°C	
As Welded	400	600	38	70	40	HRc

**REDRYING** 300°C / 2 hr

**CURRENT TYPE:** DC+, AC

**GAS ACC.** EN ISO 14175



# CEWELD 4316 Ti

4316 TI 1,6 X 250MM

Packaging	KG/unit	EanCode
Can	2	8720663411594

4316 TI 2,0 X 300MM

Packaging	KG/unit	EanCode
Can	2,4	8720663411600

4316 TI 2,5 X 300MM

Packaging	KG/unit	EanCode
Can	2,5	8720663411617

4316 TI 3,2 X 350MM

Packaging	KG/unit	EanCode
Can	2,8	8720663411624

4316 TI 4,0 X 350MM

Packaging	KG/unit	EanCode
Can	2,8	8720663411648

4316 TI 5,0 X 450MM

Packaging	KG/unit	EanCode
Can	3,2	8720663411655