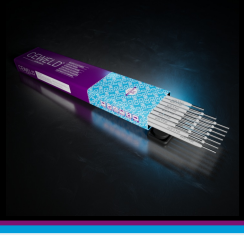


CEWELD 4430 Ti Fall

certilas® THE FILLER METAL SPECIALIST

TYPE

Rutile basic electrode for welding stainless steels in all positions. (Type 316L, 19 12 3L)

APPLICATIONS

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

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. CEWELD E 4430-Ti Fall is designed to weld in vertical down position (PG) and offers a fast freezing slag that makes it also very well suited for vertical up (PF) position.

CLASSIFICATION

AWS	A 5.4: E 316L-17
EN ISO	3581-A: E 19 12 3 L R 11
W.Nr.	1.4430
F-nr	4
FM	5

SUITABLE FOR

ISO 15608: 8.1 Austenit ≤ 19 % Cr , TÜV 1000: Gr. 21-30,
1.4583, 1.4435, 1.4436, 1.4404, 1.4406, 1.4408, 1.4401, 1.4571, 1.4580, 1.4406, 1.4521, 1.4301, 1.4306,
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
0.03	0.8	1.5	0.02	0.015	19	12	2.8

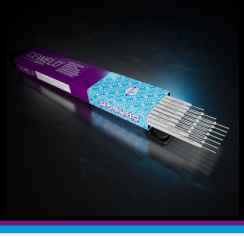
MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V	Hardness
				RT	
As Welded	350	520	32	70	HRc

REDRYING

300°C / 2 hr

GAS ACC. EN ISO 14175



CEWELD 4430 Ti Fall

certilas® THE FILLER METAL SPECIALIST

4430 TI FALL 2,0 X 300MM

Packaging	KG/unit	EanCode
Can	2,8	8720663413062

4430 TI FALL 2,5 X 300MM

Packaging	KG/unit	EanCode
Can	2,5	8720663413079

4430 TI FALL 3,2 X 350MM

Packaging	KG/unit	EanCode
Can	3,2	8720663413086