



# 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
W.Nr.	1.4430
F-nr	4
FM	5

**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

**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	
As Welded	350	600	35	70	HRc

**REDRYING** 300°C / 2 hr

**GAS ACC. EN ISO 14175**