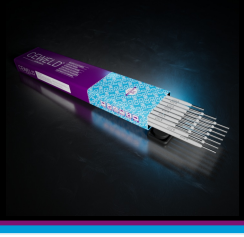


CEWELD 4332 R

certilas® THE FILLER METAL SPECIALIST

TYPE

Rutile coated electrode for welding stainless steels and dissimilar steels.

APPLICATIONS

Joining heat resistant CrNi-steels of the same kind and also joining dissimilar metals such as steel to stainless steel. Cladding on low alloyed steels in case a 18/8 CrNi layer is required in the first layer. Scale resistant up to 1050 °C.

PROPRIÉTÉS

High corrosion resistance and excellent weldability on both AC and DC+. The weld deposit can undergo a high polish due to the low carbon content.

CLASSIFICATION

AWS	A 5.4: E 309L-17
EN ISO	3581-A: E 23 12 L R 32
W.Nr.	1.4332
F-nr	4
FM	5

CONVIENT POUR

ISO 15608: 8.1 Austenit ≤ 19 % Cr , 23% Cr, 12%Ni Type
1.2780, 1.4541, 1.4550, **1.4710, 1.4712,** 1.4713, 1.4724, 1.4729, 1.4740, 1.4741, 1.4742, 1.4746, 1.4762, 1.4745, **1.4825, 1.4826, 1.4828, 1.4832, 1.4878,**
X15CrNiSi20 12, G-X 40 CrNiSi20 9,
AISI 446, AISI442, AISI309,
UNS S30900, S44200, S44600

AGRÉMENTS

CE

POSITIONS DE SOUDAGE

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S	Cr	Ni
0.03	0.7	0.7	0.02	0.01	24	13

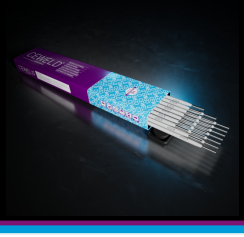
PROPRIÉTÉS MÉCANIQUES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V	Hardness
				RT	
As Welded	400	550	30	55	HRc

ETUVAGE

300°C / 2 hr

GAS ACC. EN ISO 14175



CEWELD 4332 R

4332 R 2,5 X 300MM

Packaging	KG/unit	EanCode
Can	2,4	8720663415646

4332 R 3,2 X 350MM

Packaging	KG/unit	EanCode
Can	2,8	8720663415639