



# CEWELD 316H Tig

**TYPE** Stainless steel welding wire for welding 316H high temperature steels. ( Type 19 12 3 H, 1.4403)

**APPLICATIONS** Used for welding steam piping, superheater headers, furnace parts, some gas and steam engine turbine components, in the petro-chemical industry, in fossil and nuclear fuelled power stations.

**PROPERTIES** CEWELD® 316H Tig is designed for welding 316/316H austenitic stainless steels operating at high temperatures (500-800°C) under long term creep conditions. This filler metal can also be used for welding 321/321H and 347/347H grades in high temperature structural service. This is particularly important in thick highly restrained weldments, since the possibility of premature service failure by intergranular HAZ cracking is reduced by using more ductile weld metal rather than 347H.

**CLASSIFICATION**

AWS	A 5.9: ER316H
EN ISO	14343-A: W 19 12 3 H
W.Nr.	1.4403
F-nr	6
FM	5

**SUITABLE FOR** **ISO 15608: 8.1 Austenitic ≤ 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  
 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  
 UNS S31600, S31603, S31635, S31640, S31653  
 AISI 316L, 316Ti, 316Cb, 347, 347H, 321, 321H, CF10M, BS 316S51, 316S52, 316S53, 316C16, 316C71

**APPROVALS** CE

**WELDING POSITIONS**



**TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)**

C	Si	Mn	P	S	Cr	Ni	Mo
0.06	0.6	1.8	0.01	0.01	19	13	2.5

**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	460	650	35	70		HRC

**REDRYING** Not required

**GAS ACC. EN ISO 14175** I1



# CEWELD 316H Tig

316H TIG 1,6 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663414953

316H TIG 2,0 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663415004

316H TIG 2,4 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663415042