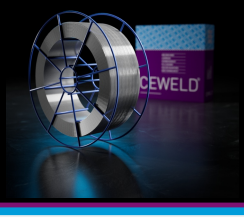


CEWELD 316H

certilas® THE FILLER METAL SPECIALIST

TYPE	Solid stainless steel welding wire with high carbon content. (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 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: G 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 (%)

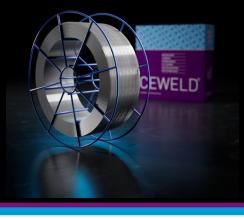
C	Si	Mn	Cr	Ni	Mo
0.06	0.5	1.8	19	13	2.5

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Hardness
As Welded	450	650	35	HRc

REDRYING: Not required

GAS ACC. EN ISO 14175: M11, M13, M12



CEWELD 316H

316H 1,0MM

Packaging	KG/unit	EanCode
BS-300	15	8720663414878

316H 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663414915