



# CEWELD 4332 R

**TYPE** Rutile coated electrode for welding stainless steels and dissimilar steels.(Type 309L, 23 12 L, 1.4332)

**APPLICATIONS** CEWELD® 4332 R is for 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.

**PROPERTIES** 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

**SUITABLE FOR** **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

**APPROVALS** CE

**WELDING POSITIONS**



**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

**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	400	550	30	55		HRc

**REDRYING** 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