



CEWELD 4430 Ti Fall

TYPE	Rutile basic electrode for welding stainless steels in all positions. (Type 316L, 19 12 3L)							
APPLICATIONS	CEWELD 4430 Ti Fall is suitable for welding corrosion-resistant Cr-Ni-Mo steels with extremely low C-content at working temperatures up to 350°C.							
PROPERTIES	CEWELD® 4430 Ti Fall is designed to weld in vertical down position (PG) and offers a fast freezing slag that makes it also very well suited for vertical up (PF) position. Weld deposit is scale-resistant up to approx. 800 °C in normal atmosphere and oxidizing gases. The weld deposit is capable of taking a high polish.							
CLASSIFICATION	AWS	A 5.4: ~E 316L-17						
	EN ISO	3581-A: E 19 12 3 L R 11						
	W.Nr.	1.4430						
	F-nr	4						
	FM	5						
SUITABLE FOR	ISO 15608: 8.1 Austenit ≤ 19 % Cr , TÜV 1000: Gr. 21-30, 1.4583, 1.4435, 1.4436, 1.4404, 1.4406, 1.4408, 1.4401, 1.4571, 1.4580, 1.4406, 1.4521, 1.4301, 1.4306, X102CrNiMoNb 18 12, X2CrNiMo 18 14 3 (TP), X4CrNiMo 17 13 3, X2CrNiMo 17 12 2 (TP), X 5CrNiMo 19 11 2, X4CrNiMo 17 12 2 (TP), X6CrNiMo 17 12 2, X6CrNiMoNb 17 12 3, X2CrNiMoN 17 12 3 (TP), X2CrMoTi18-2 316Cb, 316L, 316L, 316LN, 316H, 316, 316Ti, 316Cb, 316LN, 444 S31640, S31603, S31653, S31600, S31630, S44400							
APPROVALS	CE							
WELDING POSITIONS	 PA  PB  PC  PD  PE  PF  PG							
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	P	S	Cr	Ni	Mo
	0.03	0.8	1.5	0.02	0.015	19	12	2.8
MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness	
					RT			
	As Welded	350	520	32	70		HRc	
REDRYING	300°C / 2 hr							
GAS ACC. EN ISO 14175								



CEWELD 4430 Ti Fall

4430 TI FALL 2,0 X 300MM

Packaging	KG/unit	EanCode
Can	2,8	8720663413062

4430 TI FALL 2,5 X 300MM

Packaging	KG/unit	EanCode
Can	2,5	8720663413079

4430 TI FALL 3,2 X 350MM

Packaging	KG/unit	EanCode
Can	3,2	8720663413086