

4430 Ti Fall

CATEGORY SMAW Stick Electrodes

TYPE Rutile basic electrode for welding stainless steels in all positions

APPLICATIONS The electrode is suitable for welding corrosion-resistant Cr-Ni-Mo steels with extremely low C-content at working temperatures up to 350° C.

PROPERTIES The 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. CEWELD E 4430Ti 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.

CLASSIFICATION

AWS	A 5.4: E 316L-17 F-No. 4
EN ISO	3581-A: E 19 12 3 L R 11 FM5
DIN: W.Nr.	1.4430
DIN	8556: E19 12 3 LR 13

SUITABLE FOR	1.4583	X102CrNiMoNb 18 12	316Cb	UNS S31640
	1.4435	X2CrNiMo 18 14 3 (TP)	316L	.
	1.4436	X4CrNiMo 17 13 3	-	.
	1.4404	X2CrNiMo 17 12 2 (TP)	316L	UNS S31603
	1.4406	-	316LN	UNS S31653
	1.4408	X 5 CrNiMo 19 11 2	316H	.
	1.4401	X4CrNiMo 17 12 2 (TP)	316	UNS S31600
	1.4571	X6CrNiMo 17 12 2	316 Ti	UNS S31635
	1.4580	X6CrNiMoNb 17 12 3	316Cb	.
	1.4406	X2CrNiMoN 17 12 3 (TP)	316LN	.

APPROVALS CE approved

WELDING POSITIONS:



C	Mn	Si	Cr	Ni	Mo	Fe
<0.03	0.5-2.0	0.6	18-20	11-13	2.5-3.0	Rem

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				20°C	-40°C	-60°C	
AW	>320	>500	35	70			

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing	
D (mm)	Length (mm)	Current (A) DC+/AC	kg / can	kg / 6pack
2.0	300	40-60	2.8	16.8
2.5	300	60-90	2.5	15
3.2	350	80-110	3.2	19.2

REDRYING TEMPERATURE 300°C/2hr (not often required)