
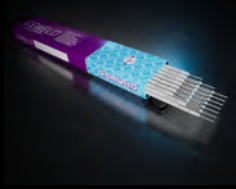


CEWELD 4430 Ti

TYPE	Beklede electrode voor het lassen van Cr-Ni-Mo 316 staalsoorten met een laag koolstofpercentage																
TOEPASSINGEN	CEWELD 4430 Ti is geschikt voor het lassen van corrosiebestendige Cr-Ni-Mo 316 staalsoorten met een extreem laag C-gehalte bij werktemperaturen tot 350°C																
EIGENSCHAPPEN	Het lasmetaal is bestand tot ca. 800 °C in normale atmosfeer en oxiderende gassen. Extreem stabiele boog op zowel AC als DC+ zonder spatverlies. Het lasmetaal is tot hoogglans te polijsten.																
CLASSIFICATIE	<table border="0"> <tr> <td>AWS</td> <td>A 5.4: E 316L-16</td> </tr> <tr> <td>EN ISO</td> <td>3581-A: E 19 12 3 LR 12</td> </tr> <tr> <td>W.Nr.</td> <td>1.4430</td> </tr> <tr> <td>F-nr</td> <td>4</td> </tr> <tr> <td>FM</td> <td>5</td> </tr> </table>	AWS	A 5.4: E 316L-16	EN ISO	3581-A: E 19 12 3 LR 12	W.Nr.	1.4430	F-nr	4	FM	5						
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GESCHIKT VOOR	<p>ISO 15608: 8.1 Austenitic ≤ 19 % Cr</p> <p>1.4301, 1.4303, 1.4306, 1.4308, 1.4311, 1.4401, 1.4404, 1.4406, 1.4408, 1.4429, 1.4435, 1.4436, 1.4438, 1.4439, 1.4541, 1.4550, 1.4552, 1.4571, 1.4580, 1.4581, 1.4583, 1.4941, 1.4948, 1.4949, 1.4961, 1.6900, 1.6901, 1.6902, 1.6903</p> <p>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</p> <p>316Cb, 316L, 316L, 316LN, 316H, 316, 316Ti, 316Cb, 316LN, 444</p> <p>S31640, S31603, S31653, S31600, S31630, S44400</p>																
GOEDKEURINGEN	CE																
LASPOSITIES																	
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> </tr> </thead> <tbody> <tr> <td>0.025</td> <td>0.85</td> <td>0.8</td> <td>0.02</td> <td>0.015</td> <td>18.5</td> <td>12</td> <td>2.5</td> </tr> </tbody> </table>	C	Si	Mn	P	S	Cr	Ni	Mo	0.025	0.85	0.8	0.02	0.015	18.5	12	2.5
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MECHANISCHE WAARDEN	<table border="1"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R_{p0,2} (MPa)</th> <th rowspan="2">R_m (MPa)</th> <th rowspan="2">A₅ (%)</th> <th colspan="2">Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness</th> </tr> <tr> <th>RT</th> <th>-110°C</th> </tr> </thead> <tbody> <tr> <td>As Welded</td> <td>460</td> <td>600</td> <td>38</td> <td>70</td> <td>60</td> <td>HRc</td> </tr> </tbody> </table>	Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness	RT	-110°C	As Welded	460	600	38	70	60	HRc
Heat Treatment	R _{p0,2} (MPa)					R _m (MPa)	A ₅ (%)		Impact Energy (J) ISO-V		Hardness						
		RT	-110°C														
As Welded	460	600	38	70	60	HRc											
HERDROGEN	300°C / 2 hr																
CURRENT TYPE	AC / DC+																
GAS ACC. EN ISO 14175																	



CEWELD 4430 Ti

4430 TI 1,6 X 250MM

Packaging	KG/unit	EanCode
Can	2,0	8720663412973

4430 TI 2,0 X 300MM

Packaging	KG/unit	EanCode
Can	2,5	8720663412980

4430 TI 2,5 X 300MM

Packaging	KG/unit	EanCode
Can	2,5	8720663412997

4430 TI 3,2 X 350MM

Packaging	KG/unit	EanCode
Can	2,6	8720663413017

4430 TI 4,0 X 350MM

Packaging	KG/unit	EanCode
Can	2,8	8720663413031