



# 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** 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 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.

**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**



**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 <sub>P0.2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	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