



# CEWELD 4316 H

**TYPE** Welding electrode for AISI 304H types Cr-Ni steel. ( Type 308H, 1.4302, 19 9 )

**APPLICATIONS** CEWELD® 4316 H is suitable for welding un-stabilized austenitic stainless steel with low carbon content, suitable for working temperatures up to 730 °C.

**PROPERTIES** Compare to the standard CEWELD® 4316 Ti the weld deposit has much higher temperature scale-resistance up to 800 °C due to the increased silicon content.

**CLASSIFICATION**

|        |                       |
|--------|-----------------------|
| AWS    | A 5.4: E 308H-16      |
| EN ISO | 3581-A: E 19 9 H R 12 |
| W.Nr.  | 1.4302                |
| F-nr   | 4                     |
| FM     | 5                     |

**SUITABLE FOR** **ISO 15608: 8.1 Austenitic ≤ 19 % Cr , TÜV 1000: Gr. 21, 9 % Ni,**  
 1.4301, 1.4308, 1.6900, 1.6901, 1.6902, 1.6903, 1.9606  
 X 5 CrNi 18 10, X 5 CrNi 18 9, G-X 6 CrNi 18 9, X 12 CrNi 18 9, G-X 8 CrNi 18 10, X 6 CrNi 18 10, X 10 CrNiTi 18 10, X 5 CrNi 18 10  
 AISI 304, 304H, 308, 308H, 321, 321H, 347, 347H,  
 UNS S30409, S32109, S34709, S30400, S32100, S34700

**APPROVALS**

**WELDING POSITIONS**



**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

| C    | Si  | Mn  | P    | S    | Cr | Ni | Mo  |
|------|-----|-----|------|------|----|----|-----|
| 0.05 | 0.5 | 1.1 | 0.02 | 0.01 | 20 | 10 | 0.2 |

**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      | 360                     | 610                  | 40                 | 70                      |  | HRc      |

**REDRYING** 300°C / 2 hr

**GAS ACC. EN ISO 14175**



# CEWELD 4316 H

4316 H 3,2 X 350MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Can       | 2,8     | 8720663411570 |

4316 H 4,0 X 450MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Can       | 2,8     | 8720663411587 |