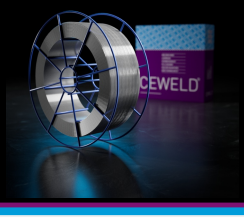


CEWELD 430 Ti

certilas® THE FILLER METAL SPECIALIST

TYPE

Stabilized ferritic filler metal for welding critical applications in exhaust manufacturing.(Typ 439, 1.4510)

APPLICATIONS

Ti Stabilized ferritic stainless steels, Austenitic stainless steels and in both homogeneous and heterogeneous sheet metal configurations (sheets of different grades welded together). CEWELD 430 Ti is an excellent choice to weld automotive exhausts as well as flues and ducts subject to moderately high temperatures. CEWELD 430 Ti can be used to weld aluminized 409 and 439 provided sufficient filler metal is added.

PROPERTIES

CEWELD 430 Ti is a 18%Cr alloy stabilized with Ti. This alloy has improved oxidation and corrosion resistance over an ER409 alloy. Single pass welds on light gage base metal or welds with preheat do not usually require PWHT.

CLASSIFICATION

AWS	A 5.9: ER439
EN ISO	14343-B: 439
W.Nr.	1.4502
F-nr	6
FM	5

SUITABLE FOR

1.4000, 1.4002, 1.4016, 1.4057, 1.4113, 1.4740, 1.4742, 1.4057, 1.4059, 1.4741, 1.4509, 1.4510, 1.4511, 1.4512, 1.4520, 1.4523, 1.4712, 1.4713, 1.4724,
X7Cr14, X12Cr13, X17CrNi16-2, X6Cr13, X6CrAl13, X6Cr17, X 6 Cr Mo 17, X17CrNi16-2, X2CrTiNb18, X3CrTi17, X3CrNb17, X2CrTi12, X2CrTi17, X10CrSi6, X10CrAlSi7, X10CrAlSi13, X10CrAlSi18
UNS S40300, S40500, S40900, S41000, S42900, S43000, S43035, S43036, S43100, S44200
AISI 403, 405, 409, 410, 429, 430, 430Cb, 430Ti, 439, 431, 442

APPROVALS

CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	Cr	Ni	Mo	Ti	Cu
0.02	0.7	0.6	18	0.2	0.04	0.5	0.09

MECHANICAL PROPERTIES

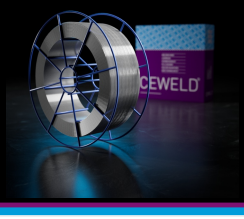
Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Hardness
As Welded	320	480	17	HRc

REDRYING

Not required

GAS ACC. EN ISO 14175

M13



CEWELD 430 Ti

430 TI 0,8MM

Packaging	KG/unit	EanCode
BS-300	15	8720663412096

430 TI 1,0MM

Packaging	KG/unit	EanCode
BS-300	15	8720663412119

430 TI 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663412126