



CEWELD 4430 H

TYPE	Rutile basic electrode for Cr-Ni-Mo steels with increased Si -content(Type 4430/ V4A)					
APPLICATIONS	CEWELD® 4430 H is suitable for welding corrosion-resistant Cr-Ni-Mo steels for working temperatures up to 400 °C.					
PROPERTIES	The weld deposit of the CEWELD® 4430 H has higher temperature scale-resistance then standard AISI 316.					
CLASSIFICATION	AWS	A 5.4: E 316H-16				
	EN ISO	3581-A: E 19 12 3 R 12				
	W.Nr.	1.4430				
	F-nr	4				
	FM	5				
SUITABLE FOR	ISO 15608: 8.1 Austenit ≤ 19 % Cr , TÜV 1000: Gr. 21, 22, 24, 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 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	 PA  PB  PC  PD  PE  PF					
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	Cr	Ni	Mo
	0.04	0.9	1	19	12	2.8
MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V	Hardness
	As Welded	350	600	35	RT	
					70	HRc
REDRYING	300°C / 2 hr					
GAS ACC. EN ISO 14175						