

## 4430H

**CATEGORY** SMAW Stick Electrodes

**TYPE** Rutile basic electrode for Cr-Ni-Mo steels with increased Si -content

**APPLICATIONS** The electrode is suitable for welding corrosion-resistant Cr-Ni-Mo steels for working temperatures up to 400° C.

**PROPERTIES** The weld deposit has higher temperature scale-resistance then standard AISI 316.

**CLASSIFICATION**

AWS	A 5.4: E 316 H-16
EN ISO	3581-A: E 19 12 3 RB 12
DIN: W.Nr.	1.4430
DIN	8556: E 19 12 3 R 12

**SUITABLE FOR** Heat resistant stainless steel with high carbon content, 316H.  
W.Nrs: 1.4401, 1.4404, 1.4410, 1.4435, 1.4436, 1.4571, 1.4573, 1.4580, 1.4583  
**AISI** : 316, 316 L, 316 Ti, 316 Cb, D 316, 317 L

**WELDING POSITIONS:**



**WELD DEPOSIT WEIGHT %**

C	Mn	Si	Cr	Ni	Mo
<0.06	0.5-2.0	1.0	18-20	11-13	2.5-3.0

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact Energy (J) ISO-V			Hardness HRC / HV
				20°C	-40°C	-60°C	
AW	320-340	550-620	35-37	70-90			

AW: as welded

**WELDING PARAMETERS PACKING**

D (mm)	Welding Parameters		Packing		
	Length (mm)	Current (A)	kg / can	kg / 6pack	kg / 1000
2.5	300	60-90	2.5	15	18.8
3.2	350	80-110	2.6	15.6	35.6
4.0	350	100-150	2.8	16.8	54.0

**REDRYING TEMPERATURE** 300°C/2hr (not often required)