

## 4316 Ti

**CATEGORY** SMAW Stick Electrodes

**TYPE** Corrosion-resistant alloy for Cr-Ni-steels with very low C-content

**APPLICATIONS** The electrode is suitable for welding corrosion-resistant Cr-Ni-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

**CLASSIFICATION**

AWS	A 5.4: E 308L-17
EN ISO	3581-A: E 19 9 L R 12
DIN: W.Nr.	1.4316
DIN	8556: E 19 9 LR 23

**SUITABLE FOR** W.Nr: 1.4300, 1.4301, 1.4306, 1.4312, 1.4371, 1.4541, 1.4543, 1.4550, 1.4452 **AISI:** 202, 302, 304, 304 L, 305, 321, 347

**APPROVALS** TUV (12536.00), CE approved

**WELDING POSITIONS:**



**WELD DEPOSIT WEIGHT %**

C	Mn	Si	Cr	Ni	Mo
<003	0.5-2.0	<0.9	18-20	9-11	-

**MECHANICAL PROPERTIES**

Heat Treatment	Rp0,2 (N/mm <sup>2</sup> )	Rm (N/mm <sup>2</sup> )	A5 (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				20°C	-40°C	-60°C	
AW	320-390	550-600	33-37	60-70			

AW: as welded

**WELDING PARAMETERS / PACKING**

Welding Parameters			Packing		
D (mm)	Length (mm)	Current (A) DC+/AC	kg / can	kg / 6pack	kg / 1000
1,6	275	40-60	2.4	14.4	6.9
2,0	300	40-60	2.4	14.4	11.3
2,5	300	50-90	2.5	15	18.3
3,2	350	90-110	2.8	16.8	34.7
4,0	350	100-150	2.8	16.8	53.2
5,0	450	150-200	3.2	19.2	106.4

**REDRYING TEMPERATURE** 300°C/2hr