

4430 Ti

CATEGORY SMAW Stick Electrodes

TYPE SMAW electrode for welding Cr-Ni-Mo steels with very low C-content

APPLICATIONS The electrode is suitable for welding corrosion-resistant Cr-Ni-Mo 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. Extreme stable arc on both AC and DC+ with no spatter losses. The weld deposit is capable of taking a high polish.

CLASSIFICATION

AWS	A 5.4: E 316L-17
EN ISO	3581-A: E 19 12 3 L R 12
DIN: W.Nr.	1.4430
DIN	8556: E 19 12 3LR23

SUITABLE FOR

1.4583	X102CrNiMoNb 18 12	316Cb	UNS S31640
1.4435	X2CrNiMo 18 14 3 (TP)	316L	.
1.4436	X4CrNiMo 17 13 3	-	.
1.4404	X2CrNiMo 17 12 2 (TP)	316L	UNS S31603
1.4406	-	316LN	UNS S31653
1.4408	X 5 CrNiMo 19 11 2	316H	.
1.4401	X4CrNiMo 17 12 2 (TP)	316	UNS S31600
1.4571	X6CrNiMo 17 12 2	316 Ti	UNS S31635
1.4580	X6CrNiMoNb 17 12 3	316Cb	.
1.4406	X2CrNiMoN 17 12 3 (TP)	316LN	.

APPROVALS TUV (12537.00), CE approved

WELDING POSITIONS:



WELD DEPOSIT WEIGHT %

C	Mn	Si	Cr	Ni	Mo	Fe
0.025	0.5-2.0	0.7	18-20	11-13	2.5-3.0	Rem

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRC / HV
				20°C	-40°C	-60°C	
AW	320	550	35	70			

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Length (mm)	Current (A) DC+/AC	kg / can	kg / 6pack	kg / 1000
2.0	300	40-60	2.5	15	12.2
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
5.0	450	155-220	3.2	19.2	96.97

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