

4576 Ti

CATEGORY	SMAW Stick Electrodes
TYPE	Rutile basic electrode for welding Cr-Ni-Mo steels with very low C-content
APPLICATIONS	Developed for welding stabilized CrNi(N) and CrNiMo(N) types and cast steels (316Ti)
PROPERTIES	Excellent corrosion resistance as needed in chemical industry up to 400°C and exceptional weldability with no spatter and self lifting slag.

CLASSIFICATION	AWS	A 5.4: E 318-16
	EN ISO	3581-A E 19 12 3 Nb R 12
	DIN: W.Nr.	1.4576
	DIN	8556: E 19 12 Nb R 23

SUITABLE FOR	1.4581	G-X5CrNiMoNb 19 11 2	-
	1.4437	G-X6CrNiMo 18 12	-
	1.4401	X4CrNiMo 17 12 2	(TP)316
	1.4571	X6CrNiMoTi 17 12 2	316Ti
	1.4580	X6CrNiMoNb 17 12 2	316Cb
	1.4583	X10-CrNiMoNb 18 12	318
	1.4436	X3CrNiMo 17 13 3	-
	⇒1.4301, 1.4541, 1.4550, 1.4404, 1.4435, 1.4473		

APPROVALS	CE approved
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WELDING POSITIONS:



WELD DEPOSIT WEIGHT %

C	Mn	Si	Cr	Ni	Mo	Nb
<0.03	0.8	0.8	18-20	11-13	2.5-3.0	10x%C

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	-120°C	
AW	>440	>600	>30	>70		>32	

AW: as welded

WELDING PARAMETERS PACKING

Welding Parameters			Packing		
D (mm)	Length (mm)	Current (A)	kg / can	kg / 6pack	kg / 1000
2.0	300	40-60	2.4	14.4	11.49
2.5	300	50-90	2.4	14.4	
3.2	350	80-110	2.8	16.8	
4.0	350	100-150	2.7	16.2	51.92
5.0	450	150-200			

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