



CEWELD 4316 Ti

TYPE Corrosion-resistant rutile-coated stick electrode for Cr-Ni steels with very low C content. (Type 308L, 19 9 L)

APPLICATIONS CEWELD 4316Ti is suitable for welding corrosion-resistant Cr-Ni steels with an extremely low C content at working temperatures of up to 350° C. Tank construction (e.g. wine tanks) and furnace construction

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-16
EN ISO	3581-A: E 19 9 L R 12
W.Nr.	1.4316
F-nr	4
FM	5

SUITABLE FOR **ISO 15608: 8.1 Austenitic ≤ 19 % Cr 9 % Ni, , TÜV 1000: Gr. 21 - 22 (29 max.350°C),**
 1.4301, 1.4306, 1.4307, 1.4308, 1.4311, 1.4312, 1.6900, 1.6901, 1.6902, 1.6903, 1.9606, 1.4541, 1.4546, 1.4550
 X 5 CrNi 18 10, X 2 CrNi 19 11, X 5 CrNi 18 9, G-X 6 CrNi 18 9, X 12 CrNi 18 9, G-X 8 CrNi 18 10, X 6 CrNi 18 10, X 10 CrNiTi 18 10, X 5 CrNi 18 10
 AISI 304, 304H, 308, 308L, 321, 321H, 347, 347H,
 UNS S30409, S32109, S34709, S30400, S32100, S34700

APPROVALS CE

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S	Cr	Ni	Fe
0.02	0.75	1	0.015	0.01	19	10	Rem.

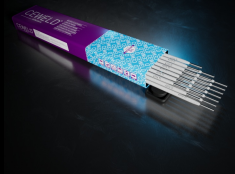
MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
				RT	-196°C	
As Welded	400	600	38	70	40	HRc

REDRYING 300°C / 2 hr

CURRENT TYPE: DC+, AC

GAS ACC. EN ISO 14175



CEWELD 4316 Ti

4316 TI 1,6 X 250MM	Packaging	KG/unit	EanCode
	Can	2	8720663411594
4316 TI 2,0 X 300MM	Packaging	KG/unit	EanCode
	Can	2,4	8720663411600
4316 TI 2,5 X 300MM	Packaging	KG/unit	EanCode
	Can	2,5	8720663411617
4316 TI 3,2 X 350MM	Packaging	KG/unit	EanCode
	Can	2,8	8720663411624
4316 TI 4,0 X 350MM	Packaging	KG/unit	EanCode
	Can	2,8	8720663411648
4316 TI 5,0 X 450MM	Packaging	KG/unit	EanCode
	Can	3,2	8720663411655