



# CEWELD 4430 H

|                |                                                                                                                                       |                        |
|----------------|---------------------------------------------------------------------------------------------------------------------------------------|------------------------|
| TYPE           | Electrode 316H rutile pour les aciers Cr-Ni-Mo à teneur accrue en Si                                                                  |                        |
| APPLICATIONS   | L'électrode convient au soudage des aciers Cr-Ni-Mo résistants à la corrosion pour des températures de travail allant jusqu'à 400 °C. |                        |
| PROPRIÉTÉS     | Le dépôt de soudure présente une résistance à l'écaillage supérieure à celle de l'AISI 316 standard.                                  |                        |
| CLASSIFICATION | AWS                                                                                                                                   | A 5.4: E 316H-16       |
|                | EN ISO                                                                                                                                | 3581-A: E 19 12 3 R 12 |
|                | W.Nr.                                                                                                                                 | 1.4430                 |
|                | F-nr                                                                                                                                  | 4                      |
|                | FM                                                                                                                                    | 5                      |

|               |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |  |
|---------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|
| CONVIENT POUR | <b>ISO 15608: 8.1 Austenit ≤ 19 % Cr , TÜV 1000: Gr. 21, 22, 24,</b><br>1.4301, 1.4303, 1.4306, 1.4308, 1.4311, 1.4401, 1.4404, 1.4406, 1.4408, 1.4429, 1.4435, 1.4436, 1.4438, 1.4439, 1.4541, 1.4550, 1.4552, 1.4571, 1.4580, 1.4581, 1.4583, 1.4941, 1.4948, 1.4949, 1.4961, 1.6900, 1.6901, 1.6902, 1.6903<br>X102CrNiMoNb 18 12, X2CrNiMo 18 14 3 (TP), X4CrNiMo 17 13 3, X2CrNiMo 17 12 2 (TP), X 5CrNiMo 19 11 2, X4CrNiMo 17 12 2 (TP), X6CrNiMo 17 12 2, X6CrNiMoNb 17 12 3, X2CrNiMoN 17 12 3 (TP), X2CrMoTi18-2<br>316Cb, 316L, 316L, 316LN, 316H, 316, 316Ti, 316Cb, 316LN, 444<br>S31640, S31603, S31653, S31600, S31630, S44400 |  |
|---------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|

|           |    |
|-----------|----|
| AGRÉMENTS | CE |
|-----------|----|

|                      |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |
|----------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| POSITIONS DE SOUDAGE |       |
|----------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|

|                                                        |      |     |    |    |    |     |
|--------------------------------------------------------|------|-----|----|----|----|-----|
| ANALYSE CHIMIQUE<br>TYPIQUE DU MÉTAL DE<br>SOUDURE (%) | C    | Si  | Mn | Cr | Ni | Mo  |
|                                                        | 0.04 | 0.9 | 1  | 19 | 12 | 2.8 |

|                       |                |                            |                         |                       |                         |          |
|-----------------------|----------------|----------------------------|-------------------------|-----------------------|-------------------------|----------|
| PROPRIÉTÉS MÉCANIQUES | Heat Treatment | R <sub>p0.2</sub><br>(MPa) | R <sub>m</sub><br>(MPa) | A <sub>5</sub><br>(%) | Impact Energy (J) ISO-V | Hardness |
|                       |                |                            |                         |                       | RT                      |          |
|                       | As Welded      | 350                        | 600                     | 35                    | 70                      | HRc      |

|         |              |
|---------|--------------|
| ETUVAGE | 300°C / 2 hr |
|---------|--------------|

|                       |  |
|-----------------------|--|
| GAS ACC. EN ISO 14175 |  |
|-----------------------|--|