CEWELD 430 Ti Tig

TYPE

Stabilized ferritic Solid Rod for welding critical applications in exhaust manufacturing.(Type 439, UNS S43035, 1.4510

APPLICATIONS

CEWELD 430 Ti Tig is an excellent choice for welding exhaust systems as well as chimneys and ducts exposed to moderately high temperatures. CEWELD 430 Ti Tig can be used to weld aluminized 409 and 439 provided sufficient filler metal is added. Application: Exhaust constructions also in sulphurous environments. Structures and piping in the chemical industry and in maritime applications. Ti Stabilized ferritic stainless steels, austenitic stainless steels in homogeneous and heterogeneous condition

PROPERTIES

CEWELD 430 Ti Tig is a 18%Cr alloy stabilized with Ti. This alloy has improved oxidation and corrosion resistance over an ER409 alloy. Single pass welds on light gage base metal or welds with preheat do not usually require PWHT. Good corrosion resistant to seawater.

CLASSIFICATION

AWS	A 5.9: ER439, A 5.9: ~ER 430 TI
EN ISO	14343-A: G Z 18 Ti, 14343-B: SS439
W.Nr.	~1.4510, 1.4502
F-nr	6
FM	5

SUITABLE FOR

1.4000, 1.4002, 1.4016, 1.4057, 1.4113, 1.4057, 1.4059, 1.4332, 1.4502, 1.4509, 1.4510, 1.4511, 1.4512, 1.4520, 1.4523, 1.4712, 1.4713, 1.4724, 1.4740, 1.4741, 1.4742, 1.4842, X7Cr14, X12Cr13, X17CrNi16-2, X6Cr13, X6CrAl13, X6Cr17, X 6 Cr Mo 17, X17CrNi16-2, X2CrTiNb18, X3CrTi17, X3CrNb17, X2CrTi12, X2CrTi17, X10CrSi6, X10CrAlSi7, X10CrAlSi13, X10CrAlSi18
UNS S40300, S40500, S40900, S41000, S42900, S43000, S43035, S43036, S43100, S44200
AISI 403, 405, 409, 410, 429, 430, 430Cb, 430Ti, 439, 431, 442

APPROVALS

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Cr	Ni	Mo	Ti	Cu
0.02	0.7	0.6	18	0.2	0.04	0.5	0.08

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Hardness
As Welded	320	480	17	225 HB

REDRYING

Not required

GAS ACC. EN ISO 14175

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