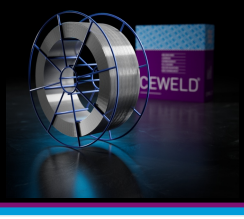


CEWELD 316H

certilas® THE FILLER METAL SPECIALIST

TYPE	Solid stainless steel welding wire with high carbon content. (Type 19 12 3 H, 1.4403)
APPLICATIONS	**CEWELD® 316H** exhibits corrosion resistance similar to matching, stabilized, austenitic **17Cr-12Ni-2Mo** steels. It is specifically designed for high-temperature service (**500-800°C**) under long-term creep conditions. **CEWELD 316H is intended for welding:** Steam pipelines and superheater headers, Furnace parts, Specific gas and steam turbine components, Applications in the petrochemical industry, Fossil-fuelled and nuclear power plants.
PROPERTIES	**CEWELD® 316H** is designed for welding austenitic 316/316H steels at high temperatures (**500-800°C**) under long-term creep conditions. This filler metal can also be used for welding 321/321H and 347/347H in high-temperature applications. This is particularly important for thick, highly restrained weld joints, as the risk of premature failure due to intergranular **HAZ (Heat Affected Zone)** cracking is reduced by using more ductile weld metal instead of 347H.

CLASSIFICATION

AWS	A 5.9: ER316H
EN ISO	14343-A: G 19 12 3 H
W.Nr.	1.4403
F-nr	6
FM	5

SUITABLE FOR

ISO 15608: 8.1 Austenitic ≤ 19 % Cr
1.4401, 1.4404 , 1.4409 , 1.4429, 1.4432, 1.4435, 1.4436, 1.4571, 1.4580, 1.4583, 1.4919
X5CrNiMo17-12-2, X2CrNiMo17-12-2, GX2CrNiMo19-11-2, X2CrNiMoN17-12-3, X2CrNiMo17-12-3, X2CrNiMo18-14-3, X3CrNiMo17-12-3, X6CrNiMoTi17-12-2, X6CrNiMoNb17-12-2, X10CrNiMoNb18-12
UNS S31600, S31603, S31635, S31640, S31653
AISI 316L, 316Ti, 316Cb, 347, 347H, 321, 321H, CF10M, BS 316S51, 316S52, 316S53, 316C16, 316C71

APPROVALS: CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

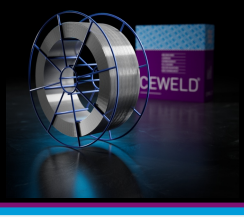
C	Si	Mn	Cr	Ni	Mo
0.06	0.5	1.8	19	13	2.5

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Hardness
As Welded	450	650	35	HRc

REDRYING: Not required

GAS ACC. EN ISO 14175: M11, M13, M12



CEWELD 316H

316H 1,0MM

Packaging	KG/unit	EanCode
BS-300	15	8720663414878

316H 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663414915