



CEWELD 4332 Ti

TYPE Rutile-basic coated electrode for welding stainless steels and dissimilar steels.(Type 309L, 23 12 L, 1.4332)

APPLICATIONS CEWELD® 4332 Ti is for joining heat resistant CrNi-steels of the same kind and also joining dissimilar metals such as steel to stainless steel. Cladding on low alloyed steels in case a 18/8 CrNi layer is required in the first layer. Scale resistant up to 1050 °C.

PROPERTIES CEWELD® 4332 Ti is a rutile basic electrode for joining heat resistant CrNi-steels of the same kind and also joining dissimilar metals such as steel to stainless steel.

CLASSIFICATION

AWS	A 5.4: E 309L-16
EN ISO	3581-A: E 23 12 L R 32
W.Nr.	1.4332
F-nr	1
FM	5

SUITABLE FOR **ISO 15608: 8.1 Austenit ≤ 19 % Cr , 23% Cr, 12%Ni Type**
 1.2780, 1.4541, 1.4550, **1.4710, 1.4712**, 1.4713, 1.4724, 1.4729, 1.4740, 1.4741, 1.4742, 1.4746,
 1.4762, 1.4745, **1.4825, 1.4826, 1.4828, 1.4832, 1.4878**,
 X15CrNiSi20 12, G-X 40 CrNiSi20 9,
 AISI 446, AISI442, AISI309,
 UNS S30900, S44200, S44600

APPROVALS CE

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S	Cr	Ni	Fe
0.02	0.5	1	0.02	0.015	24	13	Rem.

MECHANICAL PROPERTIES

Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V	Hardness
				RT	
As Welded	400	550	30	55	HRc

REDRYING 300°C / 2 hr

CURRENT TYPE AC / DC+

GAS ACC. EN ISO 14175



CEWELD 4332 Ti

4332 Ti 2,0 X 300MM

Packaging	KG/unit	EanCode
Can	2,4	8720663415578

4332 Ti 2,5 X 300MM

Packaging	KG/unit	EanCode
Can	2,4	8720663415585

4332 Ti 3,2 X 350MM

Packaging	KG/unit	EanCode
Can	2,8	8720663415592

4332 Ti 4,0 X 350MM

Packaging	KG/unit	EanCode
Can	2,8	8720663415615

4332 Ti 5,0 X 450MM

Packaging	KG/unit	EanCode
Can	3,2	8720663415622