



CEWELD 4551 Ti

TYPE Rutile-basic coated stick electrode for welding of Nb- and/or Ti-stabilized, austenitic stainless steels

APPLICATIONS CEWELD® 4551 Ti is suitable for welding austenitic corrosion-resistant stabilized Cr-Ni steels for working temperatures up to 400 °C

PROPERTIES The weld deposit of the CEWELD® 4551 Ti 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 347-16
EN ISO	3581-A: E 19 9 Nb R 12
W.Nr.	1.4551
F-nr	5
FM	5

SUITABLE FOR **ISO 15608: 8.1 (no Mo) 1.4551**
 1.4303, 1.4306, 1.4308, 1.4310, 1.4311, 1.4312, 1.4319, 1.4541, 1.4546, 1.4550, 1.4552, 1.4878
 X 6 NiTi 18 10, X 6CrNiNb 18 10, G-X 5CrNiNb 18 9, X 5CrNi 18 7, X 2CrNi 19 11, G-X 2CrNi 18 9, X
 5CrNi 18 10, X 5CrNi 18 12 G-X, 6CrNi 18 9, X 12CrNi 17 7, G-X 10CrNi 18 8
 AISI: 347, 321,302, 304, 304L, 304LN
 UNS S30400, S30403, S30453, S32100, S34700

APPROVALS CE

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S	Cr	Ni	Nb
0.03	0.8	0.8	0.015	0.01	20	10	0.24

MECHANICAL PROPERTIES

Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
				-110°C	RT	
As Welded	400	600	35	37	60	HRc

REDRYING 300°C / 2 hr

GAS ACC. EN ISO 14175



CEWELD 4551 Ti

4551 Ti 2,5 X 300MM

Packaging	KG/unit	EanCode
Can	2,4	8720663411662

4551 Ti 3,2 X 350MM

Packaging	KG/unit	EanCode
Can	2,8	8720663411679

4551 Ti 4,0 X 350MM

Packaging	KG/unit	EanCode
Can	2,7	8720663411693