



CEWELD 4316 H

TYPE Welding electrode for AISI 304H types Cr-Ni steel. (Type 308H, 1.4302, 19 9)

APPLICATIONS CEWELD® 4316 H is suitable for welding un-stabilized austenitic stainless steel with low carbon content, suitable for working temperatures up to 730 °C.

PROPERTIES Compare to the standard CEWELD® 4316 Ti the weld deposit has much higher temperature scale-resistance up to 800 °C due to the increased silicon content.

CLASSIFICATION

AWS	A 5.4: E 308H-16
EN ISO	3581-A: E 19 9 H R 12
W.Nr.	1.4302
F-nr	4
FM	5

SUITABLE FOR **ISO 15608: 8.1 Austenitic ≤ 19 % Cr , TÜV 1000: Gr. 21, 9 % Ni,**
 1.4301, 1.4308, 1.6900, 1.6901, 1.6902, 1.6903, 1.9606
 X 5 CrNi 18 10, X 5 CrNi 18 9, G-X 6 CrNi 18 9, X 12 CrNi 18 9, G-X 8 CrNi 18 10, X 6 CrNi 18 10, X 10 CrNiTi 18 10, X 5 CrNi 18 10
 AISI 304, 304H, 308, 308H, 321, 321H, 347, 347H,
 UNS S30409, S32109, S34709, S30400, S32100, S34700

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S	Cr	Ni	Mo
0.05	0.5	1.1	0.02	0.01	20	10	0.2

MECHANICAL PROPERTIES

Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V	Hardness
				RT	
As Welded	360	610	40	70	HRc

REDRYING 300°C / 2 hr

GAS ACC. EN ISO 14175



CEWELD 4316 H

4316 H 3,2 X 350MM

Packaging	KG/unit	EanCode
Can	2,8	8720663411570

4316 H 4,0 X 450MM

Packaging	KG/unit	EanCode
Can	2,8	8720663411587