



CEWELD 4455 Ti

TYPE	SMAW electrode for welding Cr-Ni-Mo steels.
TOEPASSINGEN	The electrode is suitable for welding corrosion-resistant Cr-Ni-Mo steels, austenitic steels, non-magnetic, cast steels and cold tough steels.
EIGENSCHAPPEN	Extreme stable arc on both AC and DC+ with no spatter losses. The slag is self lifting and leaves a fine rippled shiny surface.

CLASSIFICATIE	AWS	A 5.4: E 316LMn
	EN ISO	3581-A: E 20 16 3 Mn N L
	W.Nr.	1.4455
	F-nr	4
	FM	5

GESCHIKT VOOR	1.3941(G)X4CrNi18-3, 1.3945 X2CrNi18-13, 1.3948 X4CrNiMnMoN19-13-8, 1.3952 (G)X2CrNiMoN18-14-3, 1.3953 (G)X2CrNiMo18-15, 1.3955 GX12Cr18-11, 1.3965 X8CrMnNi18-8, 1.4315 X5CrNi19-9, 1.4429 X2CrNiMoN17-13-3, 1.4435 X2CrNiMo18-14-3, 1.4561 X1CrNiMoTi18-13-2, 1.6903 10CrNiTi18-10 Cryogenic 3.5 – 5% Ni-steels UNS S31603, S31653 AISI 316L, 316LN
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GOEDKEURINGEN

LASPOSITIES



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Cr	Ni	Mo
0.02	0.45	4	19	16	2.8

MECHANISCHE WAARDEN

Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness
As Welded	440	640	35	HRc

HERDROGEN	300°C / 2 hr
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GAS ACC. EN ISO 14175