

4316 H

GRUPPE SMAW Umhüllte Stabelektrode

BESCHREIBUNG Corrosion and temperature resistant electrode for AISI 304H types Cr-Ni steel

ANWENDUNG This electrode is suitable for welding un-stabilized austenitic stainless steel with low carbon content, suitable for working temperatures up to 730°C.

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

NORMBEZEICHNUNGEN

AWS	A 5.4: E 308H-16 F-No. 4
EN ISO	3581-A: E 19 9 R 12 FM5
DIN: W.Nr.	1.4948
DIN	8556: E 19 9 R 23

GEEIGNET FÜR UNS S30409 : AISI :304H W.Nr : 1.4948 UNS S32109 : AISI :321H W.Nr : 1.4941 UNS S34709 : AISI :347H W.Nr : 1.4961, 1.4300, 1.4301, 1.4303, 1.4306, 1.4308, 1.4311, 1.4312, 1.4371, 1.4541, 1.4543, 1.4550, 1.4552, 1.4948

SCHWEISS POSITIONEN:



WELD DEPOSIT WEIGHT %

C	Mn	Si	Cr	Ni	Mo
<0.05	0.5-1.0	<1.0	18-20	9-11	

REINES SCHWEISSGUT ERGEBNISSE

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRC / HV
				20°C	-40°C	-60°C	
AW	>350	>550	35	70			

AW: as welded

PARAMÈTRES DE SOUDAGE / EMBALLAGE

Welding Parameters			Packing		
D (mm)	Length (mm)	Current (A) DC+/AC	kg / can	kg / 6pack	kg / 1000
2.0	300	40-60	2.4	14.4	12.2
2.5	300	50-90	2.5	15	18.8
3.2	350	80-110	2.8	16.8	35.6
4.0	350	100-150	2.8	16.8	54.0

RÜCKTROCKNUNG Redry if necessary at 300°C/2hr (usually not needed)