



# CEWELD 4440 AC

|                |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                          |
|----------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------|
| TYPE           | Rutile basic Austenitic, non magnetic stainless steel electrode                                                                                                                                                                                                                                                                                                                                                                                                                                 |                          |
| APPLICATIONS   | CEWELD® 4440 AC made for welding stabilized and un-stabilized CrNiMo(N) type of steels with high corrosion resistance. Also suitable for dissimilar welds between steel and stainless steel or dissimilar stainless steels. Mainly used in chemical, paper and cotton industry                                                                                                                                                                                                                  |                          |
| PROPERTIES     | CEWELD® 4440 AC have high mechanical properties and excellent weldability, corrosion resistance is better than AISI 316 due to the high Mo. content. Suitable for use up to 400 °C. The weld deposit is non magnetic.                                                                                                                                                                                                                                                                           |                          |
| CLASSIFICATION | AWS                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | A 5.4: E ~317L-17        |
|                | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | 3581-A: E 18 16 5 L R 32 |
|                | W.Nr.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | 1.4440                   |
|                | F-nr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | 4                        |
|                | FM                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | 5                        |
| SUITABLE FOR   | Designed for joining corrosion resistant CrNiMoN steel as well as for austenitic-ferritic joints.<br><b>ISO 15608: 8.1 Austenitic ≤ 19 % Cr , TÜV 1000: Gr. 26, 27, 28</b><br>1.4429, 1.4434, 1.4435, 1.4436, 1.4438, 1.4439, 1.4453, 1.4583,<br>X2CrNiMoN 17 13 5, X2CrNiMoN 17 13 3, X2CrNiMo 18 15 4, X10CrNiMoNb 18 12, X2CrNiMoN17-13-3, X2CrNiMoN18-12-4, X2CrNiMo18-14-3, X3CrNiMnMoN19-16<br>UNS S31600, S31653, S31703, S31726, S31753<br>AISI 316Cb, 316L, 316LN, 317L, 317LN, 317LMN |                          |

## APPROVALS

## WELDING POSITIONS



## TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

| C    | Si  | Mn  | P    | S     | Cr | Ni | Mo  |
|------|-----|-----|------|-------|----|----|-----|
| 0.03 | 0.8 | 1.1 | 0.02 | 0.015 | 19 | 13 | 3.8 |

## MECHANICAL PROPERTIES

| Heat Treatment | R <sub>P0.2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Impact Energy (J) ISO-V | Hardness |
|----------------|-------------------------|----------------------|--------------------|-------------------------|----------|
|                |                         |                      |                    | RT                      |          |
| As Welded      | 400                     | 580                  | 32                 | 70                      | HRc      |

REDRYING 300°C / 2 hr

GAS ACC. EN ISO 14175



# CEWELD 4440 AC

4440 AC 2,5 X 300MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Can       | 2,0     | 8720663413093 |

4440 AC 3,2 X 350MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Can       | 2,5     | 8720663413109 |

4440 AC 4,0 X 350MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Can       | 2,5     | 8720663413116 |