

CEWELD 430 Ti Tig

TYPE	Stabilized ferritic Solid Rod for welding critical applications in exhaust manufacturing.(Type 439, UNS S43035, 1.4510							
APPLICATIONS	CEWELD 430 Ti Tig is an excellent choice for welding exhaust systems as well as chimneys and ducts exposed to moderately high temperatures. CEWELD 430 Ti Tig can be used to weld aluminized 409 and 439 provided sufficient filler metal is added. Application: Exhaust constructions also in sulphurous environments. Structures and piping in the chemical industry and in maritime applications. Ti Stabilized ferritic stainless steels, austenitic stainless steels in homogeneous and heterogeneous condition							
PROPERTIES	CEWELD 430 Ti Tig is a 18%Cr alloy stabilized with Ti. This alloy has improved oxidation and corrosion resistance over an ER409 alloy. Single pass welds on light gage base metal or welds with preheat do not usually require PWHT. Good corrosion resistant to seawater.							
CLASSIFICATION	AWS	A 5.9: ER439, A 5.9: ~ER 430 TI						
	EN ISO	14343-A: G Z 18 Ti, 14343-B: SS439						
	W.Nr.	~1.4510, 1.4502						
	F-nr	6						
	FM	5						
SUITABLE FOR	1.4000, 1.4002, 1.4016, 1.4057, 1.4113, 1.4057, 1.4059, 1.4332, 1.4502, 1.4509, 1.4510, 1.4511, 1.4512, 1.4520, 1.4523, 1.4712, 1.4713, 1.4724, 1.4740, 1.4741, 1.4742, 1.4842, X7Cr14, X12Cr13, X17CrNi16-2, X6Cr13, X6CrAl13, X6Cr17, X 6 Cr Mo 17, X17CrNi16-2, X2CrTiNb18, X3CrTi17, X3CrNb17, X2CrTi12, X2CrTi17, X10CrSi6, X10CrAlSi7, X10CrAlSi13, X10CrAlSi18 UNS S40300, S40500, S40900, S41000, S42900, S43000, S43035, S43036, S43100, S44200 AISI 403, 405, 409, 410, 429, 430, 430Cb, 430Ti, 439, 431, 442							
APPROVALS								
WELDING POSITIONS	 PA  PB  PC  PD  PE  PF  PG							
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	Cr	Ni	Mo	Ti	Cu
	0.02	0.7	0.6	18	0.2	0.04	0.5	0.08
MECHANICAL PROPERTIES	Heat Treatment		R _{P0,2} (MPa)	R _m (MPa)	A5 (%)	Hardness		
	As Welded		320	480	17	225 HB		
REDRYING	Not required							
GAS ACC. EN ISO 14175	I1							