

4440 AC

CATEGORY SMAW Stick Electrodes

TYPE Rutile basic Austenitic, non magnetic stainless steel electrode

APPLICATIONS 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 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 N L R 12
DIN: W.Nr.	1.4440
DIN	8556: E9-UM-300-CKR

SUITABLE FOR Designed for joining corrosionresistant CrNiMoN steel as well as for austenitic-ferritic joints.
W.Nrs:1.3941, 1.3952, 1.3953, 1.3955, 1.3958, 1.4406, 1.4429, 1.4435, 1.4438, 1.4439, 1.446, 1.448, 1.449

APPROVALS CE approved

WELDING POSITIONS:



WELD DEPOSIT WEIGHT %

C	Mn	Si	Cr	Ni	Mo	N	Fe
<0.03	3.5	0.8	18	17.5	4.5	0.12	Rem

MECHANICAL PROPERTIES

Heat treatment	RP0,2 (N/mm2)	Rm (N/mm2)	A5 (%)	Impact energy (J) ISO-V			Hardness HRc / HV
				+20C	-40°C	-60C	
AW	>400	>580	>25	>55			

AW: as welded

WELDING PARAMETERS PACKING

Welding Parameters			Packing		
D (mm)	Length (mm)	Current (A) AC/DC+	kg / can	kg / 6pack	kg / 1000
2.5	300	60-80	2.0	12	
3.2	350	80-110	2.6	15.6	
4.0	350	110-140	2.8	16.8	

REDRYING TEMPERATURE 350°C/1hr