



CEWELD 4370 Kb

TYPE Basic coated electrode for dissimilar welding and bufferlayers

APPLICATIONS CEWELD® 4370 Kb is for joint welding of difficult-to-weld steels and black/white joints, has a high plasticity and is therefore very well suited for buffer layers before overlay welding and for welding of dissimilar steels. Suitable for buffer and intermediate layers on rails and switches, for valve seats and in hydroelectric power stations

PROPERTIES CEWELD® 4370 Kb is work-hardenable, has very good cavitation resistance, is crack-proof, is resistant to thermal shock, is scale-resistant up to 850°C and largely insensitive to sigma-phase embrittlement above 500°C, is also cold-tough down to -100°C.

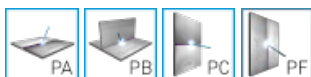
CLASSIFICATION

AWS	A 5.4: E 307-15
EN ISO	3581-A: E 18 8 Mn B 22
W.Nr.	1.4370
F-nr	5
FM	5

SUITABLE FOR **19% Cr / 9% Ni / 7% Mn, ISO 15608: 8.1 Cr ≤ 19 %**
 1.3401, 1.5637, 1.5680, 1.4370
 X 20 Cr 13, X 8 Cr 17, X 22 CrNi 17, X 5 CrNi 17, G-X 20 Cr 14 mix S355
 42CrMo4, C45, 42MnV7, X120Mn12, 10 Ni 14, 12 Ni 19 etc.
 ASTM 307, 304, (409, 403, 405, 410, 420, 430, 440, 501, 502)
 Amor, Z 120 M 12 ,

APPROVALS CE

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S	Cr	Ni
0.1	0.7	6	0.02	0.015	19	9.5

MECHANICAL PROPERTIES

Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V	Hardness
				RT	
As Welded	410	600	36	80	300 HB

REDRYING 300°C / 2 hr

GAS ACC. EN ISO 14175



CEWELD 4370 Kb

4370 KB 2,5 X 300MM

Packaging	KG/unit	EanCode
Can	2,4	8720663416230

4370 KB 3,2 X 350MM

Packaging	KG/unit	EanCode
Can	2,6	8720663416261

4370 KB 4,0 X 350MM

Packaging	KG/unit	EanCode
Can	2,8	8720663416292

4370 KB 5,0 X 450MM

Packaging	KG/unit	EanCode
Can	2,8	8720663416315