



# CEWELD 4370 HLS

|              |                                                                                                                                                                |
|--------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------|
| TYPE         | High recovery, corrosion resistant stainless steel stick electrode                                                                                             |
| APPLICATIONS | Joining steels with difficult weldability, high plasticity and therefore very well suitable for buffer layers before Hardfacing and welding dissimilar steels. |
| PROPRIÉTÉS   | Excellent weldability and scale and corrosion resistant up to 900 °C. Extreme high elongation and impact values for critical welding applications.             |

|                |        |                        |
|----------------|--------|------------------------|
| CLASSIFICATION | AWS    | A 5.4: ~E 307-26       |
|                | EN ISO | 3581-A: E 18 8 Mn R 52 |
|                | F-nr   | 1                      |
|                | FM     | 5                      |

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

|           |    |
|-----------|----|
| AGRÉMENTS | CE |
|-----------|----|

|                      |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |
|----------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| POSITIONS DE SOUDAGE |       |
|----------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|

|                                                        |     |     |    |      |       |    |    |      |
|--------------------------------------------------------|-----|-----|----|------|-------|----|----|------|
| ANALYSE CHIMIQUE<br>TYPIQUE DU MÉTAL DE<br>SOUDURE (%) | C   | Si  | Mn | P    | S     | Cr | Ni | Fe   |
|                                                        | 0.1 | 0.8 | 5  | 0.02 | 0.015 | 19 | 9  | Rem. |

|                       |                   |                            |                         |                       |                               |          |
|-----------------------|-------------------|----------------------------|-------------------------|-----------------------|-------------------------------|----------|
| PROPRIÉTÉS MÉCANIQUES | Heat<br>Treatment | R <sub>P0.2</sub><br>(MPa) | R <sub>m</sub><br>(MPa) | A <sub>5</sub><br>(%) | Impact Energy (J) ISO-V<br>RT | Hardness |
|                       | As Welded         | 370                        | 600                     | 40                    | 70                            | 180 HB   |

|         |              |
|---------|--------------|
| ETUVAGE | 300°C / 2 hr |
|---------|--------------|

|                       |  |
|-----------------------|--|
| GAS ACC. EN ISO 14175 |  |
|-----------------------|--|



# CEWELD 4370 HLS

4370 HLS 3,2 X 350MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Can       | 2,8     | 8720663416254 |

4370 HLS 4,0 X 450MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Can       | 3       | 8720663416285 |