



CEWELD OA 4370

TYPE High alloyed flux-cored wire for joining difficult to weld steel and buffer layers prior to hard facing.

APPLICATIONS Repair jobs where high strength and toughness is required. Joining austenitic manganese steels with themselves or with other steels. Buffer layer before hardfacing and maintenance on hard-to-weld steels. Armour plate and Joining 14% manganese steels.

PROPERTIES Special flux cored self shielded stainless steel wire for open arc welding
 The weld beads produced have a self-releasing slag covering that leaves a clean surface
 Sound deposits are obtained even in the presence of cross draughts
 Primary choice for cladding and rebuilding application, suitable for joining and cladding
 Provides maximum productivity for outdoor jobs

CLASSIFICATION EN ISO 14700: T Fe10

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

WELDING POSITIONS

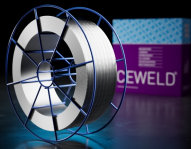


TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Mn	Cr	Ni
	0.03	6.8	19.5	8.5

MECHANICAL PROPERTIES	Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A5 (%)	Hardness
	As Welded				400 HB

REDRYING Not required

GAS ACC. EN ISO 14175



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OA 4370 1,6MM

Packaging	KG/unit	EanCode
BS-300	15	8720663417640

OA 4370 2,8MM

Packaging	KG/unit	EanCode
Drum	250	8720663417657