CEWELD OA 4370

certilas® THE FILLER METAL SPECIALIST

TYPE

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

ANWENDUNGEN

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.

EIGENSCHAFTEN

Special flux cored self shielded stainless steel wire for open arc weldingThe weld beads produced have a self-releasing slag covering that leaves a clean surfaceSound deposits are obtained even in the presence of cross draughtsPrimary choice for cladding and rebuilding application, suitable for joining and claddingProvides maximum productivity for outdoor jobs

KLASSIFIKATION

EN ISO 14700: T Fe10

GEEIGNET FÜR

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 ,

ZULASSUNGEN

SCHWEISSPOSITIONEN

TYPISCHE CHEMISCHE ANALYSE DES SCHWEISSMETALLS (%)

C	Mn	Cr	Ni
0.03	6.8	19.5	8.5

MECHANISCHE GÜTEWERTE

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Hardness
As Welded				400 HB

RÜCKTROCKNUNG

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