



CEWELD 4370 HLS

TYPE	High recovery, corrosion resistant stainless steel stick electrode																							
APPLICATIONS	CEWELD® 4370 HLS is for joint welding of difficult-to-weld steels, has a high plasticity and is therefore very well suited for buffer layers before surfacing and for welding of dissimilar steels.																							
PROPERTIES	CEWELD® 4370 HLS has excellent weldability, scale and corrosion resistance up to 900 °C, as well as extremely high elongation and impact values required for critical welding applications.																							
CLASSIFICATION	<table><tr><td>AWS</td><td>A 5.4: ~E 307-26</td></tr><tr><td>EN ISO</td><td>3581-A: E 18 8 Mn R 52</td></tr><tr><td>F-nr</td><td>1</td></tr><tr><td>FM</td><td>5</td></tr></table>								AWS	A 5.4: ~E 307-26	EN ISO	3581-A: E 18 8 Mn R 52	F-nr	1	FM	5								
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SUITABLE FOR	<p>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 ,</p>																							
APPROVALS	CE																							
WELDING POSITIONS																								
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table><tr><td>C</td><td>Si</td><td>Mn</td><td>P</td><td>S</td><td>Cr</td><td>Ni</td><td>Fe</td></tr><tr><td>0.1</td><td>0.8</td><td>5</td><td>0.02</td><td>0.015</td><td>19</td><td>9</td><td>Rem.</td></tr></table>								C	Si	Mn	P	S	Cr	Ni	Fe	0.1	0.8	5	0.02	0.015	19	9	Rem.
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MECHANICAL PROPERTIES	<table><thead><tr><th>Heat Treatment</th><th>R_{P0,2} (MPa)</th><th>R_m (MPa)</th><th>A₅ (%)</th><th colspan="2">Impact Energy (J) ISO-V</th><th>Hardness</th></tr></thead><tbody><tr><td>As Welded</td><td>370</td><td>600</td><td>40</td><td>70</td><td>RT</td><td>180 HB</td></tr></tbody></table>								Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness	As Welded	370	600	40	70	RT	180 HB		
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As Welded	370	600	40	70	RT	180 HB																		
REDRYING	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