



# 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                                | <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 ,                                                                                   |                         |                      |                    |                         |    |          |
| APPROVALS                                   | CE                                                                                                                                                                                                                                                                                                                                                                                                      |                         |                      |                    |                         |    |          |
| WELDING POSITIONS                           | <div> PA</div> <div> PB</div> <div> PC</div> <div> PF</div> |                         |                      |                    |                         |    |          |
| 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 <sub>P0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | 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 |