

## 4370 Kb

**CATEGORY** SMAW Stick Electrodes

**TYPE** Basic coated electrode for dissimilar welding and bufferlayers

**APPLICATIONS** Joining steels with difficult weldability, high plasticity and therefore very well suitable for buffer layers before hardfacing and welding dissimilar steels..

**PROPERTIES** Excellent weldability and scale and corrosion resistant up to 900°C. Extreme high elongation and impact values makes this electrode a excellent choice for critical welding applications.

**CLASSIFICATION**

AWS	A 5.4: E 307-15
EN ISO	3581-A: E 18 8 Mn B 22
DIN: W.Nr.	1.4370
DIN	8556: E 18 8 Mn B 20+

**SUITABLE FOR** Screening steels Tools steels\* Low alloyed steels \* Austenitic steels with Mn : type Z 120 M 12 Spring steels : 45S7\*, 51S7\*; 56SC7\*, 45C4\*, manganese steels, X120Mn12, 1.3401, C45, dissimilar joint welding between steel and stainless steel such as: Armor plate, high carbon steels. Recommended for welding rails, crossing, crusher teeth, hammers and applications where rolling wear is required.

**APPROVALS** CE approved

**WELDING POSITIONS:**



**WELD DEPOSIT WEIGHT %**

C	Mn	Si	Cr	Ni	Mo	Fe
<0.15	5-7	0.7	17-18	7-9	-	Rem

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact Energy (J) ISO-V			Hardness HB
				20°C	-40°C	-60°C	
AW	>350	>550	>37	>75			200-400*

\*strain hardening

**WELDING PARAMETERS / PACKING**

Welding Parameters			Packing		
D (mm)	Length (mm)	Current (A)	kg / can	kg / 6pack	kg / 1000
2.5	300	60-90	2.4	14.4	
3.2	350	80-110	2.6	15.6	
4.0	350	100-150	2.8	16.8	
5.0	350/450	150-200	3.2	19.2	

**REDRYING TEMPERATURE** 300°C/2hr (not often required).