

4370 Ti

CATEGORY SMAW Stick Electrodes

TYPE Rutile basic stainless steel 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 307-16
EN ISO	3581-A: E 18 8 Mn RB 12
DIN: W.Nr.	1.4370
DIN	8556: E 18 8 MnR26

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, XMn120Mn12, 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
<0.10	5-7	0.7	17-19	7-9	-	Rem

MECHANICAL PROPERTIES

Heat Treatment	R _{p0.2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HB
				20°C	-40°C	-60°C	
AW	370	600	40	70			200-400*

strain hardening

WELDING PARAMETERS / PACKING

D (mm)	Welding Parameters		Packing		
	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).