

OA 4370

CATEGORY FCAW Flux-Cored

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

APPLICATIONS 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.

PROPERTIES

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

CLASSIFICATION

AWS	A 5.22:
EN ISO	14700: T Fe10
DIN: W.Nr.	1.4370
DIN	8555: MF-8-GF-150/400-KPZ

SUITABLE FOR Tools steels* Low alloyed steels * Austenitic steels with Mn : type Z 120 M 12 Spring steels : 45S7*, 51S7*; 56SC7*, 45C4*, ...dissimilar welding

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS %

C	Mn	Si	Cr	Ni	Fe
0.03	6.80	0.80	19.5	8.5	rem

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				20°C	40°C	60°C	
AW	500	680	40	80			

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	spools type	kg / spool	kg / drum
1.6	24-28	150-350	S-300	15	250
2.0	26-30	200-400	S-300	15	250
2.4	26-30	250-450	S-300 / K 415	15 / 25	250
2.8	28-32	250-450	S-300 / K 415	15 / 25	250

REDRYING TEMPERATURE 150°C / 24hr.

GAS ACC. EN ISO 14750: None / open arc