




# 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	<table border="0"> <tr> <td>AWS</td> <td>A 5.4: E 307-15</td> </tr> <tr> <td>EN ISO</td> <td>3581-A: E 18 8 Mn B 22</td> </tr> <tr> <td>F-nr</td> <td>5</td> </tr> <tr> <td>FM</td> <td>5</td> </tr> <tr> <td>W.Nr.</td> <td>1.4370</td> </tr> </table>	AWS	A 5.4: E 307-15	EN ISO	3581-A: E 18 8 Mn B 22	F-nr	5	FM	5	W.Nr.	1.4370				
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EN ISO	3581-A: E 18 8 Mn B 22														
F-nr	5														
FM	5														
W.Nr.	1.4370														
SUITABLE FOR	<p><b>19% Cr / 9% Ni / 7% Mn, ISO 15608: 8.1 Cr ≤ 19 %</b>            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 border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</th> <th>Cr</th> <th>Ni</th> </tr> </thead> <tbody> <tr> <td>0.1</td> <td>0.7</td> <td>6</td> <td>0.02</td> <td>0.015</td> <td>19</td> <td>9.5</td> </tr> </tbody> </table>	C	Si	Mn	P	S	Cr	Ni	0.1	0.7	6	0.02	0.015	19	9.5
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As Welded /	410	600	36	80	Avg. 300										
REDRYING TEMPERATURE	300°C / 2 hr														
GAS ACCORDING EN 14175															



# CEWELD 4370 Kb

4370 KB 2,5 X 300MM

Type	KG/unit	EANCode
Can	2,4	8720663416230

4370 KB 3,2 X 350MM

Type	KG/unit	EANCode
Can	2,6	8720663416261

4370 KB 4,0 X 350MM

Type	KG/unit	EANCode
Can	2,8	8720663416292

4370 KB 5,0 X 450MM

Type	KG/unit	EANCode
Can	2,8	8720663416315