



CEWELD 4370 HLS

TYPE High recovery, corrosion resistant stainless steel stick electrode

APPLICATIONS CEWELD® 4370 HLS is for joint welding of difficult-to-weld steels, has a high plasticity and is therefore very well suited for buffer layers before surfacing and for welding of dissimilar steels.

PROPERTIES CEWELD® 4370 HLS has excellent weldability, scale and corrosion resistance up to 900 °C, as well as extremely high elongation and impact values required for critical welding applications.

CLASSIFICATION

AWS	A 5.4: ~E 307-26
EN ISO	3581-A: E 18 8 Mn R 52
F-nr	1
FM	5

SUITABLE FOR **19% Cr / 9% Ni / 7% Mn, ISO 15608: 8.1 Cr ≤ 19 %**
 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 ,

APPROVALS CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	P	S	Cr	Ni
	0.1	0.8	5	0.02	0.015	19	9

ALL WELD MECHANICAL PROPERTIES	Heat Treatment	R _{p0,2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V	Hardness
	As Welded /	370	600	40	RT	Brinell Hardness
					70	Avg. 300

REDRYING TEMPERATURE 300°C / 2 hr

GAS ACCORDING EN 14175



CEWELD 4370 HLS

4370 HLS 3,2 X 350MM

Type	KG/unit	EANCode
Can	2,8	8720663416254

4370 HLS 4,0 X 450MM

Type	KG/unit	EANCode
Can	3	8720663416285