



# 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	<table><tr><td>AWS</td><td>A 5.4: ~E 307-26</td></tr><tr><td>EN ISO</td><td>3581-A: E 18 8 Mn R 52</td></tr><tr><td>F-nr</td><td>1</td></tr><tr><td>FM</td><td>5</td></tr></table>								AWS	A 5.4: ~E 307-26	EN ISO	3581-A: E 18 8 Mn R 52	F-nr	1	FM	5
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EN ISO	3581-A: E 18 8 Mn R 52															
F-nr	1															
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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 (%)	C	Si	Mn	P	S	Cr	Ni	Fe								
	0.1	0.8	5	0.02	0.015	19	9	Rem.								
ALL WELD MECHANICAL PROPERTIES	Heat Treatment	R <sub>P0,2</sub> MPa	R <sub>m</sub> MPa	A5 (%)	Impact Energy (J) ISO-V RT	70	Hardness Brinell Hardness Avg. 180									
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