



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 ,
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APPROVALS	CE
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WELDING POSITIONS	     
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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 _{p0,2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V RT		Hardness Brinell Hardness	
	As Welded /	370	600	40	70		Avg. 180	

REDRYING TEMPERATURE	300°C / 2 hr
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GAS ACCORDING EN 14175	
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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