



CEWELD 4370 Ti

TYPE	Rutile basic stainless steel electrode for dissimilar welding and bufferlayers (Type 4370)										
APPLICATIONS	CEWELD® 4370 Ti 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 Ti has excellent weldability, scale and corrosion resistance up to 850°C, as well as extremely high elongation and impact values required for critical welding applications.										
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.4: E 307-16</td> </tr> <tr> <td>EN ISO</td> <td>3581-A: E 18 9 Mn Mo R 12</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 307-16	EN ISO	3581-A: E 18 9 Mn Mo R 12	F-nr	5	FM	5	W.Nr.	1.4370
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EN ISO	3581-A: E 18 9 Mn Mo R 12										
F-nr	5										
FM	5										
W.Nr.	1.4370										
SUITABLE FOR	<p>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 ,</p>										

APPROVALS CE

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S	Cr	Ni	Mo
0.09	0.9	4.5	0.02	0.015	20	10	0.5

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. 300

REDRYING TEMPERATURE 300°C / 2 hr

GAS ACCORDING EN 14175



CEWELD 4370 Ti

4370 TI 2,5 X 300MM

Type	KG/unit	EANCode
Can	2,4	8720663416223

4370 TI 3,2 X 350MM

Type	KG/unit	EANCode
Can	2,6	8720663416247

4370 TI 4,0 X 350MM

Type	KG/unit	EANCode
Can	2,8	8720663416278

4370 TI 5,0 X 350MM

Type	KG/unit	EANCode
Can	2,8	8720663416308