



CEWELD OA 4370

TYPE High alloyed flux-cored wire for joining difficult to weld steel and buffer layers prior to hard facing.

APPLICATIONS Repair jobs where high strength and toughness is required. Joining austenitic manganese steels with themselves or with other steels. Buffer layer before hardfacing and maintenance on hard-to-weld steels. Armour plate and Joining 14% manganese steels.

PROPRIÉTÉS Special flux cored self shielded stainless steel wire for open arc welding
The weld beads produced have a self-releasing slag covering that leaves a clean surface
Sound deposits are obtained even in the presence of cross draughts
Primary choice for cladding and rebuilding application, suitable for joining and cladding
Provides maximum productivity for outdoor jobs

CLASSIFICATION EN ISO 14700: T Fe10

CONVIENT POUR **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 ,

AGRÉMENTS

POSITIONS DE SOUDAGE



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Mn	Cr	Ni
0.03	6.8	19.5	8.5

PROPRIÉTÉS MÉCANIQUES

Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness
As Welded				400 HB

ETUVAGE Not required

GAS ACC. EN ISO 14175



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OA 4370 1,6MM

Packaging	KG/unit	EanCode
BS-300	15	8720663417640

OA 4370 2,8MM

Packaging	KG/unit	EanCode
Drum	250	8720663417657