



# 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.

**PROPERTIES** Special flux cored self shielded stainless steel wire for open arc weldingThe weld beads produced have a self-releasing slag covering that leaves a clean surfaceSound deposits are obtained even in the presence of cross draughtsPrimary choice for cladding and rebuilding application, suitable for joining and claddingProvides maximum productivity for outdoor jobs

**CLASSIFICATION** EN ISO 14700: T Fe10

**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**

**WELDING POSITIONS**



**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

| C    | Mn  | Cr   | Ni  |
|------|-----|------|-----|
| 0.03 | 6.8 | 19.5 | 8.5 |

**MECHANICAL PROPERTIES**

| Heat Treatment | R <sub>P0.2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Hardness |
|----------------|-------------------------|----------------------|--------------------|----------|
| As Welded      |                         |                      |                    | 400 HB   |

**REDRYING** Not required

**GAS ACC. EN ISO 14175**



# CEWELD OA 4370

OA 4370 1,6MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663417640 |

OA 4370 2,8MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Drum      | 250     | 8720663417657 |