



# CEWELD 4370 Kb

**TYPE** Basic coated electrode for dissimilar welding and bufferlayers

**APPLICATIONS** CEWELD® 4370 Kb is for joint welding of difficult-to-weld steels and black/white joints, has a high plasticity and is therefore very well suited for buffer layers before overlay welding and for welding of dissimilar steels. Suitable for buffer and intermediate layers on rails and switches, for valve seats and in hydroelectric power stations

**PROPERTIES** CEWELD® 4370 Kb is work-hardenable, has very good cavitation resistance, is crack-proof, is resistant to thermal shock, is scale-resistant up to 850°C and largely insensitive to sigma-phase embrittlement above 500°C, is also cold-tough down to -100°C.

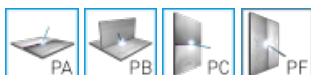
**CLASSIFICATION**

|        |                        |
|--------|------------------------|
| AWS    | A 5.4: E 307-15        |
| EN ISO | 3581-A: E 18 8 Mn B 22 |
| W.Nr.  | 1.4370                 |
| F-nr   | 5                      |
| 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 ,

**APPROVALS** CE

**WELDING POSITIONS**



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

| C   | Si  | Mn | P    | S     | Cr | Ni  |
|-----|-----|----|------|-------|----|-----|
| 0.1 | 0.7 | 6  | 0.02 | 0.015 | 19 | 9.5 |

**MECHANICAL PROPERTIES**

| Heat Treatment | R <sub>P0.2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Impact Energy (J) ISO-V | Hardness |
|----------------|-------------------------|----------------------|--------------------|-------------------------|----------|
|                |                         |                      |                    | RT                      |          |
| As Welded      | 410                     | 600                  | 36                 | 80                      | 300 HB   |

**REDRYING** 300°C / 2 hr

**GAS ACC.** EN ISO 14175



# CEWELD 4370 Kb

4370 KB 2,5 X 300MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Can       | 2,4     | 8720663416230 |

4370 KB 3,2 X 350MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Can       | 2,6     | 8720663416261 |

4370 KB 4,0 X 350MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Can       | 2,8     | 8720663416292 |

4370 KB 5,0 X 450MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Can       | 2,8     | 8720663416315 |