



# 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 ,

**APPROVALS** CE

**WELDING POSITIONS**



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

C	Si	Mn	P	S	Cr	Ni
0.1	0.8	5	0.02	0.015	19	9

**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	370	600	40	70		300 HB

**REDRYING** 300°C / 2 hr

**GAS ACC.** EN ISO 14175



# CEWELD 4370 HLS

4370 HLS 3,2 X 350MM

Packaging	KG/unit	EanCode
Can	2,8	8720663416254

4370 HLS 4,0 X 450MM

Packaging	KG/unit	EanCode
Can	3	8720663416285