



# 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 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

**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