Kjellberg® FINSTERWALDE

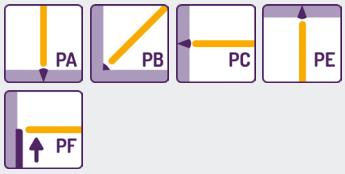
STICK ELECTRODES, DISSIMILAR STEELS

FINOX 4370 AC

Processing informatione

Re-drying: 300 – 350 °C/2 h

Welding positions:



Polarity:

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Wheter preheating is required depends on the ferritic base material, low heat input required, to avoid hard and brittle martensit weld junction. Otherwise welding without preheating possible.

High-manganese steels should be cold-welded, if possible. Larger components need to be cooled. Interpass temperature is max. 250 ° C. Massive components from unalloyed, cracksensitive steels with higher carbon content need to be pre-heated to 250 – 350 °C.

Application

Electrode for joint welding of unalloyed and low-alloyed steel with high-alloyed steel, cast steel and for austenite-ferrite-joints at working temperatures of up to 300 °C. This rod electrode is suitable for welding of difficult-to-weld steel with high carbon content as well as austenitic manganese steel, for buffering layers and for wear-resistant surfacing when exposed to work-hardening shock, pressure and rolling load. The weld metal is austenitic, corrosion-resistant, scale-resistant up to 850 °C as well as work-hardenable up to 350 HB.

All Weld Metal Mechanical Properties	
Heat Treatment	AW
Structure	Austenite
Weld Metal Composition [%]	
C 0,1 Si 0,9 Mn 6 Cr 19 Ni 9	
Yield Strength Rp 0,2 [MPa]	> 350
Tensile Strength Rm [MPa]	> 550
Elongation A5 [%]	> 35
Charpy Impact Value ISO-V [J/RT]	> 75

Welding Current, Packaging

Item no.	Dm./Länge [mm]	Amperage [A]	kg/Pack	≈ Piece/Pack	kg/1000 Pc.
00.721.250	2,50/300	70 - 100	4,0	217	18,4
00.721.323	3,25/350	100 - 140	5,0	135	37,0
00.721.403	4,00/350	130 - 170	5,0	92	54,3

Field

Characteristic

rutile-coated, core wire-alloyed

Standards

ISO 3581-A
E 18 8 Mn R 12

AWS A 5.4
≈ E 307-16

Material no.

1.4370

Approvals

THE ORIGINAL MADE IN GERMANY SINCE 1921

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