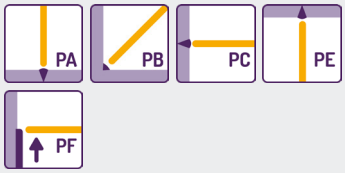
Kjellberg® FINSTERWALDE

FINOX 4370 B

Processing informatione

Re-drying: 250 – 300 °C/2 h
(if required)

Welding positions:



Polarity:

=+

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

Basic-coated stick electrode for joint and surface welding of dissimilar steels, heat-treatable, armour and high-manganese steels among each other and with one another, for austenitic-ferrite joints at working temperatures of up to 300 °C, for welding of steels with high carbon content and hard-to-weld steels. The weld metal is fully austenitic, corrosion-resistant, scale-resistant up to 850 °C and cold-hardenable up to a hardness of approx. 350 HB.

All Weld Metal Mechanical Properties	
Heat Treatment	AW
Structure	Austenite
Weld Metal Composition [%]	
C 0,1 / Si 0,5 / Mn 6,5 / Cr 19 / Ni 9	
Yield Strength Rp 0,2 [MPa]	> 350
Tensile Strength Rm [MPa]	> 600
Elongation A5 [%]	> 35
Charpy Impact Value ISO-V [J/RT]	> 100

Welding Current, Packaging

Item no.	Dm./Länge [mm]	Amperage [A]	kg/Pack	≈ Piece/Pack	kg/1000 Pc.
00.744.250	2,50/300	70 - 100	4,0	267	15,0
00.744.323	3,25/350	100 - 130	5,0	167	29,9
00.744.403	4,00/350	120 - 160	5,0	111	45,0

Field

Characteristic

basic-coated, core wire-alloyed

Standards

ISO 3581-A
E 18 8 Mn B 22

AWS A 5.4
≈ E 307-15

Material no.

1.4370

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