

## 4370 Ti

<b>CATEGORY</b>	SMAW Stick Electrodes
<b>TYPE</b>	Rutile basic stainless steel electrode for dissimilar welding and bufferlayers
<b>APPLICATIONS</b>	Joining steels with difficult weldability, high plasticity and therefore very well suitable for buffer layers before hardfacing and welding dissimilar steels..
<b>PROPERTIES</b>	Excellent weldability and scale and corrosion resistant up to 900°C. Extreme high elongation and impact values makes this electrode a excellent choice for critical welding applications.

<b>CLASSIFICATION</b>	AWS	A 5.4: E 307-16
	EN ISO	3581-A: E 18 8 Mn RB 12
	DIN: W.Nr.	1.4370
	DIN	8556: E 18 8 MnR26

<b>SUITABLE FOR</b>	Screening steels Tools steels* Low alloyed steels * Austenitic steels with Mn : type Z 120 M 12 Spring steels : 45S7*, 51S7*; 56SC7*, 45C4*, manganese steels, XMn120Mn12, 1.3401, C45, dissimilar joint welding between steel and stainless steel such as: Armor plate, high carbon steels. Recommended for welding rails, crossing, crusher teeth, hammers and applications where rolling wear is required.
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<b>APPROVALS</b>	CE approved
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**WELDING POSITIONS:**



<b>WELD DEPOSIT WEIGHT %</b>	C	Mn	Si	Cr	Ni	Mo	Fe
	<0.10	5-7	0.7	17-19	7-9	-	Rem

<b>MECHANICAL PROPERTIES</b>	Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact Energy (J) ISO-V	Hardness HB
	AW	370	600	40	20°C: 70, -40°C: , -60°C:	200-400*

strain hardening

**WELDING PARAMETERS / PACKING**

D (mm)	Welding Parameters			Packing		
	Length (mm)	Current (A)	kg / can	kg / 6pack	kg / 1000	
2.5	300	60-90	2.4	14.4		
3.2	350	80-110	2.6	15.6		
4.0	350	100-150	2.8	16.8		
5.0	350/450	150-200	3.2	19.2		

<b>REDRYING TEMPERATURE</b>	300°C/2hr (not often required).
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