

## OA 4370

**CATEGORY** FCAW Flux-Cored

**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**

AWS	A 5.22:
EN ISO	14700: T Fe10
DIN: W.Nr.	1.4370
DIN	8555: MF-8-GF-150/400-KPZ

**SUITABLE FOR** Tools steels\* Low alloyed steels \* Austenitic steels with Mn : type Z 120 M 12 Spring steels : 45S7\*, 51S7\*; 56SC7\*, 45C4\*, ...dissimilar welding

**APPROVALS** CE approved

**WELDING POSITIONS:**



**WELD METAL ANALYSIS %**

C	Mn	Si	Cr	Ni	Fe
0.03	6.80	0.80	19.5	8.5	rem

**MECHANICAL PROPERTIES**

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 HRC / HV
				20°C	40°C	60°C	
AW	500	680	40	80			

AW: as welded

**WELDING PARAMETERS / PACKING**

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	spools type	kg / spool	kg / drum
1.6	24-28	150-350	S-300	15	250
2.0	26-30	200-400	S-300	15	250
2.4	26-30	250-450	S-300 / K 415	15 / 25	250
2.8	28-32	250-450	S-300 / K 415	15 / 25	250

**REDRYING TEMPERATURE** 150°C / 24hr.

**GAS ACC. EN ISO 14750:** None / open arc