Kjellberg® FINSTERWALDE

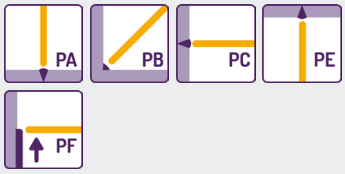
STICK ELECTRODES, DISSIMILAR STEELS

FINOX 4370 S

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.

Application

This electrode was especially designed for surface welding on rails (e.g. tramways, industrial and coal railways). Further, it is suited for joint welding of unalloyed and low-alloyed steels with high-alloyed steels, cast steel types, for austenite-ferrite joints, for welding of steels with high carbon content and hardto-weld steels as well as austenitic hard-manganese steels, for welding of buffering layers and for wear-resistant surfacing in case of cold-hardening impact, pressure and rolling load. The weld metal is fully austenitic, corrosionresistant, scale-resistant and cold-hardenable up to a hardness of 350 HB.

All Weld Metal Mechanical Properties					
Structure					Austenite
Weld Metal Composition [%]					
C	Si	Mn	Cr	Ni	
0,08	0,5	5,5	19,5	9	
Hardness [HB]					
As-welded					≈ 200
workhardened					≈ 350

Welding Current, Packaging

Item no.	Dm./Länge [mm]	Amperage [A]	kg/Pack	≈ Piece/Pack	kg/1000 Pc.
00.730.504	5,00/450	160 - 210	6,0	65	92,3
00.730.604	6,00/450	190 - 240	6,0	45	133,3

Field

Characteristic

rutile-basic-coated

Standards

ISO 3581-A
E 18 8 Mn R 12

DIN EN 14700
E Fe 10

AWS A 5.4
≈ E 307-16

Material no.

1.4370

Approvals

DB CE

rail-surfacings

.kjellberg.de

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