

CARBO S- 4370 Si

CARBO T- 4370

International standards

	S = massive wire	T = bare rod
Werkstoff Nr.	1.4370	
DIN 8559	G 18 8 Mn	W 18 8 Mn
AWS A 5.7	≈ER307	≈ER307

Approvals

TÜV, DB-Nr. 43.021.09, Ü, UDT TÜV, DB-Nr. 43.021.10, Ü, UDT

Application notes

Massive wire electrode suitable for welding difficult-to-weld, crack-sensitive steels with > 0.7 % carbon content and for joint welding of and surfacing on heat resistant stainless steels and castings.
Suitable for joint welding of austenitic to ferritic steels which are exposed to service temperatures up to 300° C.
Furthermore it can be used for welding equalizing buffer layers prior to hardfacing and for repair welding of manganese steels. Stainless, heat resistant weld metal, non-scaling up to 850° C and resistant to sulphurous waste gases at temperatures up to 500° C.
The weld metal alloy is case hardening and non-magnetic
Hardness after strain-hardening: approx. 340 HB

Operating temperature

-110° C up to + 300° C

Base materials

Combined compound of 1.4583 with H I / H II, 17 Mn 4, StE 355
1.4583 with P235GH / P256GH, P295GH, P355N
Surfacing on rails with an Rm of 685 N/mm²

Mechanical properties of all-weld-metal

(typical values)

Tensile strength R _m N/mm ²	Yielding strength R _{p0,2} N/mm ²	Elongation A ₅ %	Impact strength ISO – V J at -40° C
600	320	40	100

Weld metal analysis

(typical, wt %)

C	Si	Mn	Cr	Ni
0,08	0,8	7,0	19,0	9,0

Gas types EN 439

S = massive wire

M12, M13, M21

T = bare rod

I1

Current

	= +				= -				
Diameter mm	0,8	1,0	1,2	1,6	1,6	2,0	2,4	3,2	4,0
Welding amps (A) min.	80	120	180	250					
(A) max.	130	190	250	320					

coils, weight

Rev. 000

B300 15 kg.

10 kg.