

CARBO 4370 B

International standards	Material No.	1.4370
	EN 1600	E 18 8 Mn B 22
	AWS A 5.4	E307-15 / MOD.
	DIN 8555	E 8-UM-200-CKNPZ

Approvals DB

Characteristics and typical applications

CARBO 4370 B is a basic coated electrode with an alloyed core, 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, CARBO 4370 B 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 - 20° 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	Yield strength R _{p0.2} N/mm ²	Elongation A ₅ %	Impact strength ISO-V J at 20° C	Hardness HB
600	>400	> 32	> 32	180

Weld metal analysis %
(typical)

C	Si	Mn	Cr	Ni
0,10	0,5	6	19	9

Current = + / ~

Welding positions PA, PB, PC, PD, PE, PF

Rebaking 1 h, 350° C + / - 10° C (if necessary)

Dia./Length	Amperage (A)	Pcs./packet	Pcs./carton	kg/1000	kg/packet	kg/carton
2,5 x 300	60 – 75	253	1013	15,8	4,0	16,0
3,2 x 350	95 – 110	161	643	31,1	5,0	20,0
4,0 x 350	100 – 140	106	425	47,1	5,0	20,0
5,0 x 450	130 – 190	63	254	94,5	6,0	24,0
6,0 x 450	150 – 260	45	178	134,5	6,0	24,0