

Standards	Material No.	1.4370
	AWS	~ E 307
	DIN 8555	MF8-GF-200-CKNPZ

Characteristics and typical applications CARBO F-4370 is 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. Furthermore, CARBO F-4370 can be used for welding equalizing buffer layers prior to hardfacing and for repair welding of manganese steels. Stainless, heat resistant weld metal. The weld metal alloy is case hardening and non-magnetic. Hardness after strain-hardening: approx. 340 HB

Working temperature Rt. 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,

Recommendations for fabrication 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 + 20°C
	600	>400	> 32	>32

Mechanical properties of all-weld metal (typical values)	Hardness HB as welded	Hardness after strain-hardening
	180 HB	approx. 340 HB

Weld metal analysis (typical, wt %)	C	Si	Mn	Cr	Ni
	0,06	0,4	6,5	19	8,5

Gas types EN 439 I1, M13: Argon and 99% Argon with 1% Oxygen
Current = +

Current intensity	DIA (mm)	DIA (inch)	Volt	Amps	Delivering form	
	1,2	3/64	19 - 22	120 - 220		
	1,6	1/16	20 - 26	160 - 260	O	G
	2,0	5/64	22 - 27	220 - 280	O	G
	2,4	3/32	24 - 28	260 - 340	O	G
	2,8	7/64	25 - 29	300 - 400	O	S
	3,2	1 / 8	26 - 30	320 - 460		S

Delivering form **O = Flux cored wire self shielding**
G = Flux cored wire for shielded arc welding
S = Flux cored wire for submerged arc welding

Coils, weight B/BS 300 = 15 kg B 450 = 30 kg pay off pack = 150 / 300 kg

Rev. 000

Statements on composition and application are just for the applier's information. Statements on mechanical properties always refer to the all-weld-metal according to valid standards. Carbo-Weld may change the characteristics of its products without notice. We recommend the applier to check our products for their special application autonomously.