

Processing information

Re-drying: 150 - 200 °C/2 h

Welding positions:



Polarity:



Whether preheating is required depends on the base material.

Application

Nickel-base electrode for high-quality crack-resistant joint welding and plating on the same nickelchromium-ferrous alloys, (heat-resistant) Cr and CrNi (Mo, N) steels and nickel-alloyed coldtough pressure tank steels. For austenite-ferrite joints (e.g. 14583 with 16Mo3) Usable at working temperatures between -196 °C and 800 °C (in case of sulphurous atmosphere only up to 500 °C).

The fully austenitic weld metal is chemically stable, cold-tough, heat-resistant, scale-resistant up to 1,000 °C and resistant against embrittlement.

Materials

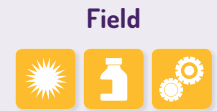
1.4876	X 10 NiCrAlTi 32-21	- Alloy 600
2.4816	NiCr 15 Fe	- Alloy 800

All Weld Metal Mechanical Properties

Heat Treatment	AW						
Structure	Austenite						
Weld Metal Composition [%]							
C	Si	Mn	Cr	Mo	Nb	Fe	Ni
0,05	0,5	6	16	1	2	8	B
Yield Strength Rp 0,2 [MPa]		> 350					
Tensile Strength Rm [MPa]		> 620					
Elongation A5 [%]		> 35					
Charpy Impact Value ISO-V [J/RT]		> 90					

Welding Current, Packaging

Item no.	Dm./Länge [mm]	Amperage [A]	kg/Pack	≈ Piece/Pack	kg/1000 Pc.
00.760.253	2,50/350	80 - 110	5,0	177	28,2
00.760.323	3,25/350	110 - 140	5,0	105	47,6
00.760.403	4,00/350	140 - 180	5,0	70	71,4



Field

**Characteristic
basic-coated**

**Standards
ISO 14172
= E Ni 6182
(Ni Cr 15 Fe6Mn)**

**AWS A 5.11
E NiCrFe-3**

**Material no.
2.4620**



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