

Processing information

Whether preheating is required depends on the ferritic base material, low heat input required, otherwise welding without preheating possible.

Re-drying: 300 - 350 °C/2 h

Welding positions:



Polarity:



Application

Rutile-coated stick electrode for welding of identical martensitic ferrite steels if austenitic CrNi types cannot be used; e.g. in case of sulphurous gases; suited for surfacing on sealing surfaces of fittings made from unalloyed and low-alloyed steels (up to 450 °C), scale-resistant up to 850 °C.

Field



Characteristic
rutile-coated,
alloyed through
coating

Standards

ISO 3581-A
E 13 R 52

EN 14700
E Fe 7

AWS A 5.4
E 410-26

Material no.

1.4009

Materials

1.4000	X 6 Cr 13	1.4024	X 15 Cr 13
1.4002	X 6 CrAl 13	1.4027	GX 20 Cr 14
1.4006	X 12 Cr 13	-	AISI 410, AISI 420
1.4021	X 20 Cr 13		

All Weld Metal Mechanical Properties

Heat Treatment	750 °C/2 h		
Structure	Ferrite/Martensite		
Weld Metal Composition [%]			
C	Si	Mn	Cr
0,06	0,5	0,6	13
Yield Strength Rp 0,2 [MPa]		> 420	
Tensile Strength Rm [MPa]		> 500	
Elongation A5 [%]		> 17	

Welding Current, Packaging

Item no.	Dm./Länge [mm]	Amperage [A]	kg/Pack	≈ Piece/Pack	kg/1000 Pc.
00.709.323	3,25/350	90 - 160	5,0	99	50,5
00.709.403	4,00/350	120 - 220	5,0	65	76,9



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