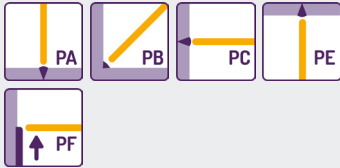


Processing information

Re-drying: 300 - 350 °C/2 h

Welding positions:



Polarity:



Application

Electrode for joint welding on corrosion-resistant duplex steel. The austenitic-ferritic weld metal is especially resistant against pitting corrosion and stress corrosion cracking.

Field



**Characteristic
rutile-coated,
core wire-alloyed**

Standards

**ISO 3581-A
E22 9 3 N L R 12**

**AWS A 5.4
E 2209-17**

Material no.

1.4462

Approvals



Materials

1.4460	X 3 CrNiMoN 27-5-2
1.4462	X 2 CrNiMoN 22-5-3
1.4463	GX 6 CrNiMo 24-8-2
1.4582	X 4 CrNiMoNb 25-7

All Weld Metal Mechanical Properties

Heat Treatment	AW					
Structure	Austenite / Ferrite (Duplex)					
Weld Metal Composition [%]						
C	Si	Mn	Cr	Ni	Mo	N
0,03	0,9	1	22	9	3	0,12
Yield Strength Rp 0,2 [MPa]		> 500				
Tensile Strength Rm [MPa]		> 700				
Elongation A5 [%]		> 25				
Charpy Impact Value ISO-V (J/RT)		> 50				

Welding Current, Packaging

Item no.	Dm./Länge [mm]	Amperage [A]	kg/Pack	≈ Piece/Pack	kg/1000 Pc.
00.708.250	2,50/300	70 - 100	4,0	215	18,6
00.708.323	3,25/350	100 - 130	5,0	137	36,5
00.708.403	4,00/350	120 - 160	5,0	90	55,6



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