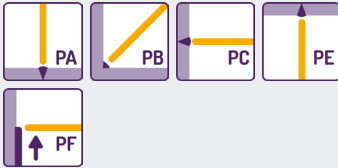


### Processing information

Re-drying: 300 - 350 °C/2 h

Welding positions:



Polarity:



Whether preheating is required depends on the base material, usually not necessary.

### Application

Electrode for joint welding and surfacing on austenitic chromium-nickel-molybdenum-copper steel and cast steel of the same grade. The weld metal has a higher corrosion-resistance against reducing media.

### Field



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

**Standards**  
**ISO 3581-A**  
**E20 25 5 Cu N L R 32**

**AWS A 5.4**  
**E 385-16**

**Material no.**  
**1.4519**

**Approvals**



### Materials

1.4500	GX 7 NiCrMoCuNb 25-20
1.4505	X 4 NiCrMoCuNb 20-18-2
1.4506	X 5 NiCrMoCuTi 20-18
1.4531	GX 2 NiCrMoCuN 20-18
1.4536	GX 2 NiCrMoCuN 25-20
1.4538	GX 1 NiCrMoCuN 25-20-5
1.4539	X 1 NiCrMoCu 25-20-5
1.4585	GX 7 CrNiMoCuNb 18-18
1.4586	X 5 NiCrMoCuNb 22-18

### All Weld Metal Mechanical Properties

<b>Heat Treatment</b>	AW					
<b>Structure</b>	Austenite					
<b>Weld Metal Composition [%]</b>						
C	Si	Mn	Cr	Ni	Mo	Cu
0,03	0,9	1,5	20	25	4,5	1,5
<b>Yield Strength Rp 0,2 [MPa]</b>		> 400				
<b>Tensile Strength Rm [MPa]</b>		> 550				
<b>Elongation A5 [%]</b>		> 35				
<b>Charpy Impact Value ISO-V (J/RT)</b>		> 55				

### Welding Current, Packaging

Item no.	Dm./Länge [mm]	Amperage [A]	kg/Pack	= Piece/Pack	kg/1000 Pc.
00.726.250	2,50/300	70 - 100	4,0	147	27,2
00.726.323	3,25/350	110 - 140	5,0	92	54,3
00.726.403	4,00/350	130 - 170	5,0	61	82,0



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