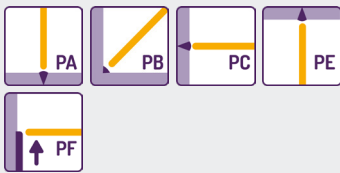


Processing information

Whether preheating is required depends on the base material, otherwise not necessary. Interpass temperature max. 150 °C.

Re-drying: 300 - 350 °C/2 h

Welding positions:



Polarity:



Application

Electrode for joint welding on unstabilised and stabilised austenitic, chemically stable chromium-nickel-molybdenum steel at working temperatures of up to 400 °C. This stainless steel electrode is also suitable for corrosion-resistant chromium steel and claddings of similar alloys.

Field



Characteristic
rutile-coated,
core wire-alloyed

Standards
ISO 3581-A
E 19 12 3 Nb R 12

AWS A 5.4
E 318-16

Material no.
1.4576

Approvals



Materials			
1.4401	X 5 CrNiMo 17-12-2	1.4436	X 3 CrNiMo 17-13-3
1.4404	X 2 CrNiMo 17-12-2	1.4571	X 6 CrNiMoTi 17-12-2
1.4406	X 2 CrNiMoN 17-11-2	1.4580	X 6 CrNiMoNb 17-12-2
1.4408	GX 5 CrNiMo 19-11-2	1.4581	GX5 CrNiMoNb 19-11-2
1.4409	GX 2 CrNiMo 19-11-2	1.4583	X10 CrNiMoNb 18-12
1.4429	X 2 CrNiMoN 17-13-3	-	AISI 316 AISI 316L AISI 316 Cb AISI 316Ti
1.4435	X 2 CrNiMo 18-14-3		

All Weld Metal Mechanical Properties	
Heat Treatment	AW
Structure	Austenite with approx. 8 % ferrite
Weld Metal Composition [%]	
C	Si
0,03	0,9
Mn	Cr
0,8	18,5
Ni	Mo
11,5	2,7
Nb	
0,3	
Yield Strength Rp 0,2 [MPa]	> 380
Tensile Strength Rm [MPa]	> 550
Elongation A5 [%]	> 30
Charpy Impact Value ISO-V [J/RT]	> 55

Welding Current, Packaging

Item no.	Dm./Länge [mm]	Amperage [A]	kg/Pack	= Piece/Pack	kg/1000 Pc.
00.704.200	2,00/300	60 - 80	4,0	350	11,4
00.704.250	2,50/300	80 - 100	4,0	220	18,2
00.704.323	3,25/350	100 - 130	5,0	138	36,2
00.704.403 *	4,00/350	120 - 160	5,0	93	53,8

* This product is not a standard stock article. Produced only to customer order. Ask for an individual quotation.



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Kjellberg Finsterwalde
Elektroden und
ZusatzMaterials GmbH
Ludwig-Erhard-Str. 12
03238 Finsterwalde
Germany

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Kjellberg Finsterwalde

+49 3531 50768-0

✉ elektrode@kjellberg.de