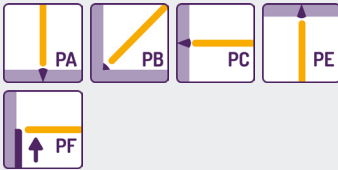


### Processing information

Re-drying: 300 - 350 °C/2 h

Welding positions:



Polarity:



### Application

Double coated basic electrode for high quality and crack resistant joint welding in machine construction, steel fabrication, boiler construction. It is characterised by good welding properties in fixed positions.

### Field



**Characteristic**  
**basic-coated,**  
**double-coated**

**Standards**  
**ISO 2560-A**  
**E 46 3 B 22 H5**  
**AWS A 5.1**  
**E 7018-1**

### Approvals



Materials	
Construction steels	S275 - S355
Fine-Grained steels	S275 - S460
Ship steels	A32/36, D32/36, E32/36, F32/36, A/D/E40
Boiler steels	P195 - P460
Pipe steels	L210 - L450
Cast steels	GE200, GE240, GP240, G21Mn5
Reinforcing steels	BSt 420, BSt 500

All Weld Metal Mechanical Properties	
Heat Treatment	AW
Weld Metal Composition [%]	
C	Si
0,07	0,6
Mn	1
Yield Strength Re [MPa]	> 460
Tensile Strength Rm [MPa]	550-600
Elongation A5 [%]	> 25
Charpy Impact Value ISO-V [J/-30°C]	> 70

### Welding Current, Packaging

Item no.	Dia./Length [mm]	Amperage [A]	kg/Pack	= Piece/Pack	kg/1000 Pc.
00.150.253*	2,50/350	80 - 100	4,3	198	21,7
00.150.323*	3,25/350	100 - 130	4,5	127	35,4
00.150.404*	4,00/450	120 - 160	5,6	82	68,3

\* This product is not a standard stock article. All dimensions are produced only to customer order. Ask for an individual quotation.



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