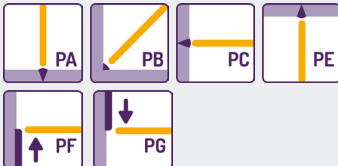


Processing information

Welding positions:



Polarity:



Application

Stick electrode with excellent welding properties in all positions. Suitable for joint welding and repair welding on unalloyed mild steel in all Fields of the metal-working industry and in craft. The electrode is easy in application. It is characterised by good bridgeability, easy ignition and re-ignition and low spatter. The result is a smooth, finely rippled seam surface and easy slag removal even on slightly rusty and primed base materials.

Materials

Construction steels	S235 - S355
Ship steels	A, B, D, A32/36, D32/36 P195 -
Boiler steels	P355
Pipe steels	L210 - L360
Cast steels	GE 200, GE2400, GP240, GE21Mn5
Reinforcing steels	BSt 420, BSt 500

All Weld Metal Mechanical Properties

Heat Treatment	AW	
Weld Metal Composition [%]		
C	Si	Mn
0,07	0,3	0,6
Yield Strength Re [MPa]	> 430	
Tensile Strength Rm [MPa]	520 - 600	
Elongation A5 [%]	> 24	
Charpy Impact Value ISO-V [J/-10°C]	> 70	

Welding Current, Packaging

Item no.	Dia./Length [mm]	Amperage [A]	kg/Pack	≈ Piece/Pack	kg/1000 Pc.
00.915.162	1,60/250	40 - 60	1,5	250	6,0
00.915.202	2,00/250	50 - 80	1,6	175	9,1
00.915.253	2,50/350	70 - 100	4,8	252	19,0
00.915.323	3,25/350	110 - 140	4,8	147	32,7
00.915.403	4,00/350	130 - 170	4,8	103	46,6

Field



Characteristic
rutile-cellulosic-coated

Standards
ISO 2560-A
E42 0 RC 11
AWS A 5.1
E 6013

Approvals



.kjellberg.de

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