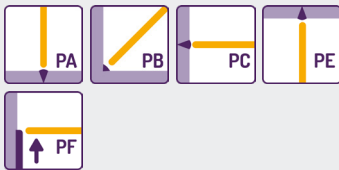


### Processing information

Preheating and interpass temperature from 250 up to 350 °C depending on base material, shape of material and thickness.

Re-drying: 300 - 350 °C/2 h

Welding positions:



Polarity:



Tempering: min. 0.5 h at 700 °C  
down-cooling at resting air

Annealing: 0.5 h at 950 °C down-cooling by air, afterwards 0.5 h at 700 °C down-cooling by air

### Application

Electrode for joint welding on boiler and pipe steel as well as similar chromiummolybdenum-alloyed, pressure-hydrogen-resistant steel. Preferably, this rod electrode is used for the steel 13CrMo4-5 at working temperatures of up to 550 °C. Further, it is well suited for joint welding and surfacing on similar-alloyed case-hardened and heat-treated steel.

Field



Characteristic  
**basic-coated**

Standards  
**ISO 3580-A  
E CrMo 1 B 42**

**AWS A 5.5  
E 8018-B2**

Approvals



### Materials

<b>1.7218</b>	25 CrMo 4	<b>1.7335</b>	13 CrMo 4-5
<b>1.7218</b>	G 25 CrMo 4	<b>1.7337</b>	16 CrMo 4-4
<b>1.7254</b>	20 CrMo 4	<b>1.7350</b>	22 CrMo 4-4
<b>1.7258</b>	24 CrMo5	<b>1.7354</b>	G22 CrMo 5-4
<b>1.7262</b>	15 CrMo 5		

### All Weld Metal Mechanical Properties

<b>Heat Treatment</b>	A
<b>Weld Metal Composition [%]</b>	
C	0,08
Si	0,4
Mn	1,0
Cr	1,0
Mo	0,5
<b>Yield Strength Re [MPa]</b>	> 400
<b>Tensile Strength Rm [MPa]</b>	510-650
<b>Elongation A5 [%]</b>	> 20
<b>Charpy Impact Value ISO-V [J/+20 °C]</b>	> 80

### Welding Current, Packaging

Item no.	Dia./Length [mm]	Amperage [A]	kg/Pack	= Piece/Pack	kg/1000 Pc.
<b>00.490.253</b>	2,50/350	90 - 110	4,3	192	22,4
<b>00.490.323</b>	3,25/350	110 - 150	4,8	140	34,3
<b>00.490.403</b>	4,00/350	140 - 180	4,8	94	51,1



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