

Processing information

Re-drying: 250 – 300 °C/2 h

Welding positions:



Polarity:



Whether preheating is required depends on the base material, for surfacing at crack-sensitive materials up to 400 °C.

Application

Electrode for highly heat-resistant, corrosion-resistant surfacings with good thermal shock resistance abilities. It is especially suitable for repairs and fabrication of hot working tools, for example forging dies, die blocks, press jacks, piercers, trimming cutters etc. This stick electrode is also ideal for surfacings on unalloyed and low-alloyed high-tensile steel. The weld metal is corrosion-resistant under oxidising and reducing conditions, especially tough and crack-resistant, creep-resistant and hardenable at approx. 780 °C. It is workhardenable under shock load and mechanically workable.

All Weld Metal Mechanical Properties

Weld Metal Composition [%]

C	Cr	Mo	W	Fe	Co	Ni
0,06	16	17	4,5	5	2,5	B

Yield Strength Rp 0,2 [MPa] > 390

Tensile Strength Rm [MPa] > 680

Elongation A5 [%] 40

Hardness [HB]

As-welded ≈ 220

Workhardened ≈ 400

Welding Current, Packaging

Item no.	Dm./Länge [mm]	Amperage [A]	kg/Pack	≈ Piece/Pack	kg/1000 Pc.
00.617.253	2,50/350	70 – 100	5,0	145	34,5
00.617.323	3,25/350	120 – 140	5,0	88	56,8
00.617.403	4,00/350	160 – 190	5,0	57	87,7

Field



Characteristic
rutile-coated,
180 % recovery

Standards
DIN EN 14700
E Z Ni 2
DIN 8555
E 23-UM-250 CNKPTZ

ISO 14172
NI 6275/
Ni Cr 15 Mo 16 Fe 5 W 3

AWS A 5.11
E Ni Cr Mo-5

Material no.
≈ 2.4887



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