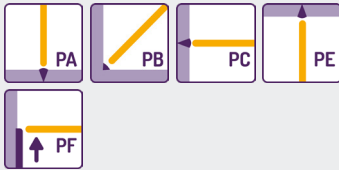


Processing information

Re-drying: 300 - 350 °C/2 h

Welding positions:



Polarity:



Whether preheating is required depends on the base material, otherwise not necessary. Interpass temperature max. 200 °C.

Application

Electrode for joint welding of unalloyed and low-alloyed steel with high-alloyed steel, cast steel and for austenite-ferrite joints at working temperatures of up to 300 °C. It is suitable for welding of buffering layers and claddings, where the first layer should be corrosion-resistant as well as for welding of transition zones on chromium-nickel-cladded plates.

Field



Characteristic
rutile-coated,
core wire-alloyed

Standards
ISO 3581-A
E 23 12 L R 32
AWS A 5.4
E 309 L-16

Material no.
1.4332

Approvals



All Weld Metal Mechanical Properties

Heat Treatment AW

Structure Austenite with approx. 15% Ferrite

Weld Metal Composition [%]

C	Si	Mn	Cr	Ni
0,02	0,9	0,7	23	13

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.
00.722.250	2,50/300	80 - 100	4,0	221	18,1
00.722.323	3,25/350	100 - 130	5,0	139	36,0
00.722.403	4,00/350	120 - 160	5,0	92	54,3



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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