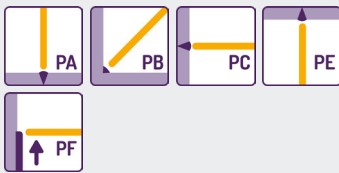


Processing information

Whether preheating is required depends on the base material, otherwise not necessary. Interpass temperature max. 150 °C.

Re-drying: 300 - 350 °C/2 h

Welding positions:



Polarity:



Application

Electrode for joint welding on unstabilised and stabilised austenitic, chemically stable chromium-nickel steel at working temperatures of up to 400 °C, for corrosion-resistant chromium steel as well as claddings of similar alloys.

Field



Characteristic
rutile-coated,
core wire-alloyed

Standards

ISO 3581-A
E 19 9 Nb R 12

AWS A 5.4
E 347-16

Material no.

1.4551

Approvals



Materials

1.4301	X 5 CrNi 18-10	1.4550	X 6 CrNiNb 18-10
1.4306	X 2 CrNi 19-11	1.4552	GX 5 CrNiNb 19-11
1.4311	X 2 CrNiN 18-10	-	AISI 304 AISI 304L
1.4541	X 6 CrNiTi 18-10	-	AISI 304LN AISI 321 AISI 347

All Weld Metal Mechanical Properties

Heat Treatment	AW				
Structure	Austenite with approx. 8 % ferrite				
Weld Metal Composition [%]					
C	Si	Mn	Cr	Ni	Nb
0,02	0,9	0,8	19,0	9,5	0,3
Yield Strength Rp 0,2 [MPa]		> 350			
Tensile Strength Rm [MPa]		> 550			
Elongation A5 [%]		> 25			
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.
00.702.250	2,50/300	80 - 100	4,0	224	17,9
00.702.323	3,25/350	100 - 130	5,0	139	36,0
00.702.403	4,00/350	120 - 160	5,0	92	54,3



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