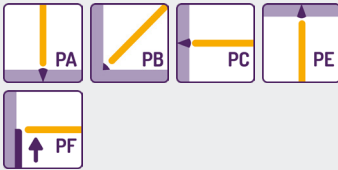


Processing information

Re-drying: 300 - 350 °C/2 h

Welding positions:



Polarity:



Application

Electrode for high-quality and crack-resistant joint welding in machine construction, steel fabrication, boiler and ship construction. Also suitable for steels with higher carbon, phosphor and sulphur content. Special coating provides lower moisture absorption (LMA type).

Field



**Characteristic
basic-coated**

Standards
ISO 2560-A
E 46 4 B 42 H5
AWS A 5.1
E 7018-1

Approvals



Materials

Construction steels	S275 - S355
Fine-Grained steels	S275 - S460
Ship steels	A32/36, D32/36, E32/36, F32/36, A/D/E40
Boiler steels	P195 - P460
Pipe steels	L210 - L450
Cast steels	GE200, GE240, GP240, G20Mn5, G21Mn5
Reinforcing steels	BSt 420, BSt 500

All Weld Metal Mechanical Properties

Heat Treatment	AW	
Weld Metal Composition [%]		
C	Si	Mn
0,07	0,5	1,3
Yield Strength Re [MPa]	> 460	
Tensile Strength Rm [MPa]	540-600	
Elongation A5 [%]	> 24	
Charpy Impact Value ISO-V [J/-40°C 46°C]	> 90 > 50	

Welding Current, Packaging

Item no.	Dia./Length [mm]	Amperage [A]	kg/Pack	= Piece/Pack	kg/1000 Pc.
00.110.253	2,50/350	90 - 120	4,6	209	22,0
00.110.323	3,25/350	120 - 160	4,8	133	36,1
00.110.404	4,00/450	150 - 190	6,0	88	68,2



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