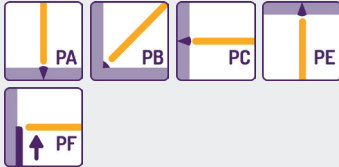


Processing information

Re-drying: 300 - 350 °C/2 h

Welding positions:



Polarity:



Application

With a molybdenum content of 0.4 % in the weld metal, the electrode is suitable for steel 16Mo3. By adding a low nickel content this stainless steel electrode is tough at low temperatures up to -30 °C. It is especially suitable for pipe steel.

Field



**Characteristic
basic-coated**

Standards
ISO 3580-A
E Mo Z B 42
ISO 2560-A
E 50 4 1 NiMoB 42

**AWS A 5.5
E 7018-A1**

Approvals



Materials	
Construction steels	S275 bis S355
Fine-Grained steels	S275 bis S500
Ship steels	A32/36, D32/36, E32/36, F32/36, A/D/E/F40
Boiler steels	P195 bis P500, 16Mo3
Pipe steels	L210 bis L450
Cast steels	GE200, GE240, GP240, G20Mo5, G21Mn5
Betonstahl	BSt 420, BSt 500

All Weld Metal Mechanical Properties				
Heat Treatment	SR			
Weld Metal Composition [%]				
C	Si	Mn	Ni	Mo
0,08	0,5	1,4	0,6	0,4
Yield Strength Re [MPa]	> 550			
Tensile Strength Rm [MPa]	580-620			
Elongation A5 [%]	> 24			
Charpy Impact Value ISO-V [J/-20 °C]	> 100			

Welding Current, Packaging

Item no.	Dia./Length [mm]	Amperage [A]	kg/Pack	= Piece/Pack	kg/1000 Pc.
00.500.253	2,50/350	90 - 110	4,6	215	21,4
00.500.323	3,25/350	110 - 150	5,0	146	34,2
00.500.404	4,00/450	140 - 180	6,0	92	65,2
00.500.504	5,00/450	180 - 220	6,0	60	100,0



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