

Processing information

Whether preheating is required depends on the ferritic base material. Thickness of the material greater than 10 mm: preheating 100 - 150 °C, otherwise welding without preheating possible

Re-drying: 250 - 300 °C/2 h (if required)

Welding positions:



Polarity:



Post weld heat treatment: is required depends on the base material.

Application

Basic-coated high-performance electrode for welding of identical softmartensitic chromium steels or cast steel types; excellently suited for plating of highly stressed parts in power plant and water utilities construction - wear and cavitation-resistant.

Field



Characteristic
basic-coated,
alloyed through
coating

Standards
ISO 3581-A
E 13 4 B 52
AWS A 5.4
E 410 NiMo-15

Material no.
1.4351

Materials

1.4313	X 3 CrNiMo 13-4	1.4413	X 3 CrNiMo 13-4
1.4317	GX 4 CrNi 13-4	1.4414	GX 4 CrNiMo 13-4

All Weld Metal Mechanical Properties

Heat Treatment	600 °C/2 h				
Structure	Martensite				
Weld Metal Composition [%]					
C	Si	Mn	Cr	Ni	Mo
0,05	0,5	0,8	13	4,5	0,45
Yield Strength Rp 0,2 [MPa]		> 600			
Tensile Strength Rm [MPa]		> 800			
Elongation A5 [%]		> 15			

Welding Current, Packaging

Item no.	Dm./Länge [mm]	Amperage [A]	kg/Pack	= Piece/Pack	kg/1000 Pc.
00.747.324	3,25/450	110 - 140	5,3	93	57,0
00.747.404	4,00/450	130 - 170	5,3	61	86,9



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