

Processing information

When welding heat-resistant Cr-steels preheating and interpass temperature of 200 to 300 °C is recommended, otherwise no preheating (attention: brittleness properties of base material). Post weld heat treatment only in dependence on base material necessary.

Re-drying: 300 - 350 °C/2 h

Welding positions:



Polarity:



Application

Electrode for joint welding and surfacing on heat-resistant chromium and chromiumnickel steel and cast steel of the same or similar alloy at working temperatures of up to 1,100 °C and rustless, corrosion-resistant molybdenum-free chromium(-nickel) steel and cast steel. The ferriteic-austenitic weld metal is scale-resistant at air and oxidising (combustion) gases up to 1,100 °C and shows good resistance against reducing, sulphur-containing (combustion) gases.

Field



Characteristic
rutile-coated, alloyed
through coating

Standards

ISO 3581-A
E 25 4 R 52

Material no.

1.4820

Materials

1.4710	GX 30 CrSi7	1.4742	X 10 CrAlSi18
1.4713	X 10 CrAlSi7	1.4762	X 10 CrAl 25
1.4724	X 10 CrAlSi13	1.4821	X 15 CrNiSi 25-4
1.4740	GX 40 CrSi17	1.4823	GX 40 CrNiSi 27-4

All Weld Metal Mechanical Properties

Heat Treatment	AW			
Structure	Ferrite with approx. 20 % austenite			
Weld Metal Composition [%]				
C	Si	Mn	Cr	Ni
0,06	0,8	1	26	4,5
Yield Strength Rp 0,2 [MPa]		> 500		
Tensile Strength Rm [MPa]		> 700		
Elongation A5 [%]		> 15		
Charpy Impact Value ISO-V RT [J]		> 20		
Hardness [HB]		180		

Welding Current, Packaging

Item no.	Dia./Length [mm]	Amperage [A]	kg/Pack	= Piece/Pack	kg/1000 Pc.
00.711.253*	2,50/350	80 - 110	5,0	169	29,6
00.711.323*	3,25/350	110 - 140	5,0	103	48,5
00.711.403*	4,00/350	130 - 170	5,0	68	73,5

* This product is not a standard stock article. All dimensions are produced only to customer order. Ask for an individual quotation.

+49 3531 50768-0

elektrode@kjellberg.de



.kjellberg.de

Kjellberg Finsterwalde
Elektroden und
ZusatzMaterials GmbH
Ludwig-Erhard-Str. 12
03238 Finsterwalde
Germany

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