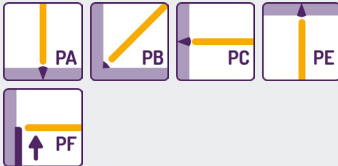


Processing information

Welding positions:



Polarity:



Application

Electrode for a wide range of applications in industry and craft. It is especially suitable for joint welding of unalloyed and low-alloyed steel in vehicle, container, boiler and pipeline construction, ship building, steel construction and engineering. The electrode has excellent ignition properties and produces a smooth arc and low spatter. The seam surface is finely rippled and smooth, the slag is mostly self-lifting. The electrode allows a flat concave fillet.

Field



**Characteristic
rutile-coated**

**Standards
ISO 2560-A
E42 0 RR 12
AWS A 5.1
E 6013**

Approvals



Materials	
Construction steels	S235 - S355
Fine-Grained steels	S275 - S355
Ship steels	A32/36, D32/36, A40, D40
Boiler steels	P195 - P355
Pipe steels	L210 - L360
Cast steels	GE200, GE240, GP240, G21Mn5
Reinforcing steels	BSt 420, BSt 500

All Weld Metal Mechanical Properties	
Heat Treatment	AW
Weld Metal Composition [%]	
C	Si
0,08	0,4
Mn	0,6
Yield Strength Re [MPa]	> 450
Tensile Strength Rm [MPa]	510-610
Elongation A5 [%]	> 22
Charpy Impact Value ISO-V [J/0°C]	> 60

Welding Current, Packaging

Item no.	Dia./Length [mm]	Amperage [A]	kg/Pack	= Piece/Pack	kg/1000 Pc.
00.231.202	2,00/250	60 - 80	1,7	192	8,6
00.231.253	2,50/350	80 - 100	4,6	206	22,3
00.231.323	3,25/350	100 - 130	4,6	123	37,4
00.231.324	3,25/450	100 - 130	6,0	125	48,0
00.231.403	4,00/350	120 - 160	4,6	85	54,1
00.231.404	4,00/450	120 - 160	6,0	83	72,3
00.231.504	5,00/450	160 - 200	6,0	52	115,4



.kjellberg.de

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

Copyright © 2018 | E18-12-06E
Kjellberg Finsterwalde

+49 3531 50768-0

elektrode@kjellberg.de