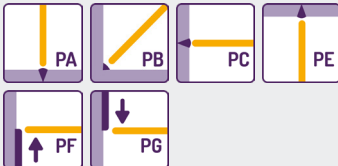


Processing information

Welding positions:



Polarity:



Application

General purpose electrode with coarse to medium-fine drop transfer for joint and tack welding. Also suitable for vertical down positions.

Field



Characteristic
rutile-coated

Standards
**ISO 2560-A
E42 0 R 12
AWS A 5.1
E 6012**

Approvals



Materials	
Construction steels	S235 - S355
Ship steels	A, B, D, A32/36, D32/36
Boiler steels	P195 - P355
Pipe steels	L210 - L360
Cast steels	GE200, GE240, GP240, G20Mo5, G21Mn5
Reinforcing steels	BSt 420, BSt 500

All Weld Metal Mechanical Properties	
Heat Treatment	AW
Weld Metal Composition [%]	
C	Si Mn
0,08	0,2 0,5
Yield Strength Re [MPa]	> 420
Tensile Strength Rm [MPa]	500-550
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.
00.900.323	3,25/350	120 - 160	5,3	177	29,9
00.900.403	4,00/350	150 - 190	5,3	116	45,7



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