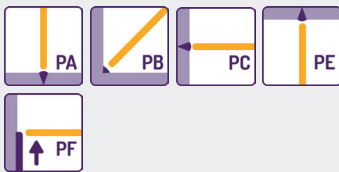


### Processing information

Preheating and interpass temperature 250 up to 350 °C depending on base material, shape of material and thickness.

Re-drying: 300 - 350 °C/2 h

Welding positions:



Polarity:



Tempering: min. 0.5 h at 700 °C  
down-cooling at resting air

Annealing: 0.5 h at 950 °C down-cooling by air, afterwards 0.5 h at 700 °C down-cooling by air

### Application

Electrode for joint welding on boiler and pipe steel as well as similar chromiummolybdenum-alloyed, pressure-hydrogen-resistant steel. It is preferred for longterm use on the creep-resistant steel 10CrMo9-10 at working temperatures of up to 600 °C. Further, it is suitable for joint welding and surfacing on similar-alloyed case-hardened and heat-treated steel.

Field



Characteristic  
**basic-coated**

Standards  
**ISO 3580-A**  
**E CrMo 2 B 42**  
**AWS A 5.5**  
**E 9018-B3**

Approvals



Materials			
<b>1.7259</b>	26 CrMo 7	<b>1.7380</b>	10 CrMo 9-10
<b>1.7273</b>	24 CrMo 10	<b>1.7382</b>	G19 CrMo 9-10
<b>1.7276</b>	10 CrMo 11	<b>1.7383</b>	11 CrMo 9-10
<b>1.7281</b>	16 CrMo 9-3	<b>1.7387</b>	G12 CrMo 9-10
<b>1.7379</b>	G17 CrMo 9-10	<b>1.8075</b>	10 CrSiMoV 7
	<b>ASTM</b>		A 335 (P22)

All Weld Metal Mechanical Properties					
<b>Heat Treatment</b>					A
<b>Weld Metal Composition [%]</b>					
C	Si	Mn	Cr	Mo	
0,08	0,4	0,9	2,2	1,1	
<b>Yield Strength Re [MPa]</b>					> 400
<b>Tensile Strength Rm [MPa]</b>					500 - 600
<b>Elongation A5 [%]</b>					> 20
<b>Charpy Impact Value ISO-V [J/+20 °C]</b>					> 47

### Welding Current, Packaging

Item no.	Dia./Length [mm]	Amperage [A]	kg/Pack	= Piece/Pack	kg/1000 Pc.
<b>00.491.323</b>	3,25/350	90 - 110	4,8	143	33,6
<b>00.491.403</b>	4,00/350	110 - 150	4,8	95	50,5
<b>00.491.504</b>	5,00/450	140 - 180	6,0	58	103,4



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