

Processing information

Re-drying: 100 – 150 °C/1 h
(if required)

Welding positions:



Polarity:



The weld zone has to be cleaned thoroughly; the cast skin has to be removed from weld edge of the base material. When welding cast iron it is important that the heat input is as low as possible, therefore, select low current. Further, the weld bead width should not be more than twice of electrode diameter; the length max. ten times. For reducing the tension the weld should be hammered just after welding.

Application

Stick electrode which is especially used for buffering layers and single-layer surfacing on scaled and/or corroded cast parts. Not suitable for filler layers and joint welding. Filler layers are produced with FICAST NI / FICAST NIFE.

Field



Characteristic

**Iron-base electrode
with special cover**

Standards

ISO 1071

E C Fe-1

AWS A 5.15

= E St

All Weld Metal Mechanical Properties

Weld Metal Composition [%]

C	Si	Mn	Fe
1,1	0,6	0,7	B

Hardness [HB] ≈ 350

Welding Current, Packaging

Item no.	Dm./Länge [mm]	Amperage [A]	kg/Pack	= Piece/Pack	kg/1000 Pc.
00.006.323	3,25/350	90 – 120	5,0	85	58,8
00.006.403	4,00/350	110 – 150	5,0	56	89,3



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