

### Processing information

Re-drying: 150 - 200 °C/2 h  
(if required)

Welding positions:



Polarity:



Whether preheating is required depends on the base material. Slow down cooling.

### Application

High-performance electrode with 240 % recovery for highly wear-resistant surfacing on tools and machine parts which are subject to heavy abrasive and impact wear, for surface and repair welding, e.g. on excavators and crushers in mines and stone quarries, in the cement industry. Special carbides (Cr-Nb-Mo-W-V) ensure an excellent wear-resistance at increased temperatures of up to 500 °C.

### Field



**Characteristic**  
**rutile-coated,**  
**240 % recovery**

**Standards**  
**DIN EN 14700**  
**E Fe16**  
**DIN 8555**  
**E 10-UM-65 GRZ**

### All Weld Metal Mechanical Properties

#### Weld Metal Composition [%]

C	Cr	Mo	Nb	W	V
5	22	7	7	2	1

#### Hardness [HB]

As-welded	63 - 65
-----------	---------

### Welding Current, Packaging

Item no.	Dm./Länge [mm]	Amperage [A]	kg/Pack	= Piece/Pack	kg/1000 Pc.
00.635.323	3,25/350	130 - 170	5,0	81	61,7
00.635.404	4,00/450	160 - 200	6,0	50	120,0
00.635.504	5,00/450	200 - 250	6,0	32	187,5



 .kjellberg.de

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

Copyright © 2018 | E18-12-72E  
Kjellberg Finsterwalde

 +49 3531 50768-0

 elektrode@kjellberg.de