

Processing informatione

Re-drying: 300 – 350 °C/2 h
(if required)

Welding positions:



Polarity:



Whether preheating is required depends on the base material. Welding with low heat input required to avoid hard and brittle martensitic dilution zones. Otherwise welding without

Application

This electrode is used for wear-resistant surfacings on machine parts which are exposed to heavy rolling and squeezing load (rolling friction), for example track switches, rail frogs and cross pieces. Furthermore, it is suitable for intermediate claddings for stress equalisation on hard-surfacings and for crack-resistant surfacings on difficult-to-weld materials with a higher carbon content and hardmanganese steel as well as heat-resistant and stainless steel and cast steel at working temperatures of up to 300°C. The austenitic weld metal is stainless, heat and scale-resistant up to 850°C and resistant against sulphur-containing combustion gases up to max. 500°C, thermal shock-resistant, non-magnetic and work-hardenable.

Field



**Characteristic
rutile-coated**

**Standards
DIN EN 14700
E Fe10
DIN 8555
E 8-UM-200 CKNZ**

**Material no.
1.4370**

All Weld Metal Mechanical Properties

Weld Metal Composition [%]

C	Si	Mn	Cr	Ni
0,1	0,9	6	19	9

Hardness [HB]

As-welded	≈ 180
workhardened	≈ 350

Welding Current, Packaging

Item no.	Dm./Länge [mm]	Amperage [A]	kg/Pack	≈ Piece/Pack	kg/1000 Pc.
00.614.253	2,50/350	90 - 110	5,0	157	31,8
00.614.324	3,25/450	110 - 150	6,0	87	69,0
00.614.404	4,00/450	140 - 180	6,0	57	105,3
00.614.504	5,00/450	180 - 220	6,0	36	166,7



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