

Processing information

Re-drying: 300 – 350 °C/2 h

Welding positions:



Polarity:



Preheating and interpass temperature depending on base material, shape and size of work piece up to 150 to 400 °C.

Application

Cobalt-base electrode for surfacings against corrosion, erosion and cavitation under heavy impact and shock load and high temperatures (800-1,000 °C depending on the application). As well it is characterised by good thermal shock resistance abilities. It is ideal for sealing surfaces at gas, damp, water and acid armatures, valve seats on combustion engines, hot extruder nozzles and hot log shears.

Field



**Characteristic
rutile-coated**

Standards
DIN EN 14700
E Co2
DIN 8555
E 20-UM-40 CTZ
AWS A 5.13
E Co Cr-A

All Weld Metal Mechanical Properties

Weld Metal Composition [%]

C	Si	Mn	Cr	W	Fe	Co
1	0,9	1	27	4,5	< 3	B

Hardness [HRC]

at RT	≈ 40
at 300 °C	≈ 35
at 600 °C	≈ 30

Welding Current, Packaging

Item no.	Dm./Länge [mm]	Amperage [A]	kg/Pack	= Piece/Pack	kg/1000 Pc.
00.616.323	3,25/350	110 - 140	5,0	141	35,5
00.616.403	4,00/350	130 - 170	5,0	96	52,1



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

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Kjellberg Finsterwalde

+49 3531 50768-0

elektrode@kjellberg.de