

Processing information

Whether preheating is required depends on the ferritic base material, low heat input required, to avoid hard and brittle martensite weld junction. Otherwise welding without preheating possible.

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

Welding positions:



Polarity:



Application

Rutile-coated high-performance electrode for welding of stainless, heat-resistant and cold-tough steels and cast steel types, on identical ferrite and similar heat-treatable steels/cast steel types; suited for surfacing and plating on sealing surfaces of water, steam and gas fittings made from unalloyed and lowalloyed steels/cast steel.

This electrode is ideally suited for surfacing on rails subject to wear and can be used for the refurbishment and repair of tramways, industrial and coal railways - for working temperatures of up to 475 °C, weld metal hardness in case of surfacing: first layer approx. 300HB (un-annealed).

Field



Characteristic
rutile-coated,
alloyed through
coating

Standards

ISO 3581-A
E 17 R 52

EN 14700
E Fe 7

AWS A 5.4
E 430-26

Material no.

1.4015

Materials

1.4057	X 17 CrNi 16-2	1.4510	X 3 CrTi 17
1.4059	GX 22 CrNi 17	-	AISI 430Ti, AISI 431

All Weld Metal Mechanical Properties

Heat Treatment	750 °C/2 h		
Structure	Ferrite/Martensite		
Weld Metal Composition [%]			
C	Si	Mn	Cr
0,08	0,6	0,5	17
Yield Strength Rp 0,2 [MPa]		> 350	
Tensile Strength Rm [MPa]		> 550	
Elongation A5 [%]		> 20	

Welding Current, Packaging

Item no.	Dm./Länge [mm]	Amperage [A]	kg/Pack	≈ Piece/Pack	kg/1000 Pc.
00.770.403	4,00/350	120 - 160	5,0	66	75,7
00.770.504	5,00/450	160 - 200	6,0	39	153,8
00.770.604	6,00/450	190 - 240	6,0	28	214,3



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