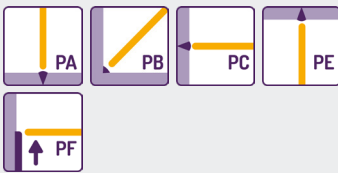


### Processing information

Whether preheating is required depends on the base material, otherwise not necessary. Interpass temperature max. 150 °C.

Re-drying: 300 - 350 °C/2 h

Welding positions:



Polarity:



### Application

Electrode for joint welding on low-carbon, unstabilised and stabilised austenitic, chemically stable chromium-nickel steel at working temperatures of up to 350 °C, for corrosion-resistant chromium steel, for cold-tough austenitic steel as well as claddings of similar alloys.

### Field



**Characteristic**  
**rutile-coated,**  
**core wire-alloyed**

### Standards

**ISO 3581-A**  
**E 19 9 L R 12**  
**AWS A 5.4**  
**E 308 L-16**

### Material no.

**1.4316**

### Approvals



### Materials

<b>1.4301</b>	X 5 CrNi 18-10	<b>1.4541</b>	X 6 CrNiTi 18-10
<b>1.4306</b>	X 2 CrNi 19-11	-	AISI 304 AISI 304L AISI 304LN AISI 321
<b>1.4311</b>	X 2 CrNiN 18-10		

### All Weld Metal Mechanical Properties

<b>Heat Treatment</b>	AW			
<b>Structure</b>	Austenite with approx. 8 % ferrite			
<b>Weld Metal Composition [%]</b>				
C	Si	Mn	Cr	Ni
0,02	0,9	0,8	19,5	9,5
<b>Yield Strength Rp 0,2 [MPa]</b>		> 350		
<b>Tensile Strength Rm [MPa]</b>		> 550		
<b>Elongation A5 [%]</b>		> 35		
<b>Charpy Impact Value ISO-V [J/RT]</b>		> 70		

### Welding Current, Packaging

Item no.	Dm./Länge [mm]	Amperage [A]	kg/Pack	≈ Piece/Pack	kg/1000 Pc.
<b>00.701.200</b>	2,00/300	60 - 80	4,0	348	11,5
<b>00.701.250</b>	2,50/300	80 - 100	4,0	221	18,1
<b>00.701.323</b>	3,25/350	100 - 130	5,0	139	36,0
<b>00.701.403</b>	4,00/350	120 - 160	5,0	91	54,9
<b>00.701.504</b>	5,00/450	160 - 200	6,0	55	109,1



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