

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

This stainless steel electrode was especially developed for welding in vertical down position. Electrode for joint welding on low-carbon, unstabilised and stabilised, austenitic, chemically stable chromium-nickel-molybdenum steel at working temperatures of up to 400 °C. It is also suitable for corrosion-resistant chromium steel and claddings of similar alloy.

Field



Characteristic
rutile-coated,
core wire-alloyed

Standards

ISO 3581-A
E 19 12 3 L R 11
AWS A 5.4
E 316 L-16

Material no.

1.4430

Materials

1.4401	X 5 CrNiMo 17-12-2	1.4435	X 2 CrNiMo 18-14-3
1.4404	X 2 CrNiMo 17-12-2	1.4436	X 3 CrNiMo 17-13-3
1.4406	X 2 CrNiMoN 17-11-2	1.4571	X 6 CrNiMoTi 17-12-2
1.4408	GX 5 CrNiMo 19-11-2	1.4580	X 6 CrNiMo- Nb 17-12-2
1.4409	GX 2 CrNiMo 19-11-2	-	AISI 316 AISI 316L AISI 316 Cb AISI 316Ti
1.4429	X 2 CrNiMoH 17-13-3		

All Weld Metal Mechanical Properties

Heat Treatment	AW				
Structure	Austenite with approx. 8 % ferrite				
Weld Metal Composition [%]					
C	Si	Mn	Cr	Ni	Nb
0,02	0,9	0,8	19,0	12,5	2,7
Yield Strength Rp 0,2 [MPa]		> 350			
Tensile Strength Rm [MPa]		> 550			
Elongation A5 [%]		> 30			
Charpy Impact Value ISO-V [J/RT]		> 60			

Welding Current, Packaging

Item no.	Dm./Länge [mm]	Amperage [A]	kg/Pack	≈ Piece/Pack	kg/1000 Pc.
00.706.250	2,50/300	80 - 100	4,0	236	16,9
00.706.323	3,25/350	100 - 130	5,0	152	32,9



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