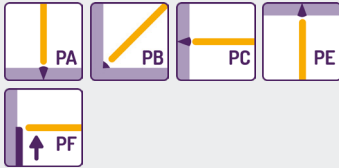


### Processing information

Re-drying: 300 - 350 °C/2 h

Welding positions:



Polarity:



### Application

Electrode for joint welding on corrosion-resistant duplex steel. The austenitic weld metal has a ferrite content of approx. 40 to 50 % and is especially resistant against pitting corrosion and stress corrosion cracking.

Field



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

Standards

**ISO 3581-A  
E22 9 3 N L R 12**

**AWS A 5.4  
E 2209-17**

Material no.

**1.4462**

Approvals



### Materials

<b>1.4460</b>	X 3 CrNiMoN 27-5-2
<b>1.4462</b>	X 2 CrNiMoN 22-5-3
<b>1.4463</b>	GX 6 CrNiMo 24-8-2
<b>1.4582</b>	X 4 CrNiMoNb 25-7

### All Weld Metal Mechanical Properties

<b>Heat Treatment</b>	AW					
<b>Structure</b>	Austenite with approx. 7 % ferrite					
<b>Weld Metal Composition [%]</b>						
C	Si	Mn	Cr	Ni	Mo	N
0,03	0,9	1	22	9	3	0,12
<b>Yield Strength Rp 0,2 [MPa]</b>		> 500				
<b>Tensile Strength Rm [MPa]</b>		> 700				
<b>Elongation A5 [%]</b>		> 25				
<b>Charpy Impact Value ISO-V (J/RT)</b>		> 50				

### Welding Current, Packaging

Item no.	Dm./Länge [mm]	Amperage [A]	kg/Pack	≈ Piece/Pack	kg/1000 Pc.
<b>00.708.250</b>	2,50/300	70 - 100	4,0	215	18,6
<b>00.708.323</b>	3,25/350	100 - 130	5,0	137	36,5
<b>00.708.403</b>	4,00/350	120 - 160	5,0	90	55,6



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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