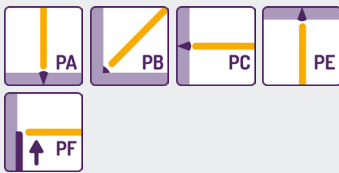


### Processing information

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 unstabilised and stabilised austenitic, chemically stable chromium-nickel-molybdenum steel at working temperatures of up to 400 °C. This stainless steel electrode is also suitable for corrosion-resistant chromium steel and claddings of similar alloys.

### Field



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

**Standards**  
**ISO 3581-A**  
**E 19 12 3 Nb R 12**

**AWS A 5.4**  
**E 318-16**

**Material no.**  
**1.4576**

### Approvals



### Materials

<b>1.4401</b>	X 5 CrNiMo 17-12-2	<b>1.4436</b>	X 3 CrNiMo 17-13-3
<b>1.4404</b>	X 2 CrNiMo 17-12-2	<b>1.4571</b>	X 6 CrNiMoTi 17-12-2
<b>1.4406</b>	X 2 CrNiMoN 17-11-2	<b>1.4580</b>	X 6 CrNiMo-Nb 17-12-2
<b>1.4408</b>	GX 5 CrNiMo 19-11-2	<b>1.4581</b>	GX5 CrNiMo-Nb 19-11-2
<b>1.4409</b>	GX 2 CrNiMo 19-11-2	<b>1.4583</b>	X10 CrNiMo-Nb 18-12
<b>1.4429</b>	X 2 CrNiMoH 17-13-3	-	AISI 316 AISI 316L AISI 316 Cb AISI 316Ti
<b>1.4435</b>	X 2 CrNiMo 18-14-3		

### All Weld Metal Mechanical Properties

**Heat Treatment** AW

**Structure** Austenite with approx. 8 % ferrite

### Weld Metal Composition [%]

C	Si	Mn	Cr	Ni	Mo	Nb
0,03	0,9	0,8	18,5	11,5	2,7	0,3

**Yield Strength Rp 0,2 [MPa]** > 380

**Tensile Strength Rm [MPa]** > 550

**Elongation A5 [%]** > 30

**Charpy Impact Value ISO-V [J/RT]** > 55

### Welding Current, Packaging

Item no.	Dm./Länge [mm]	Amperage [A]	kg/Pack	= Piece/Pack	kg/1000 Pc.
<b>00.704.200</b>	2,00/300	60 - 80	4,0	350	11,4
<b>00.704.250</b>	2,50/300	80 - 100	4,0	220	18,2
<b>00.704.323</b>	3,25/350	100 - 130	5,0	138	36,2
<b>00.704.403</b>	4,00/350	120 - 160	5,0	93	53,8
<b>00.704.504</b>	5,00/450	160 - 200	6,0	55	109,1

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