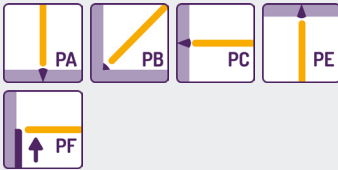


Processing information

Re-drying: 300 - 350 °C/2 h

Welding positions:



Polarity:



Application

Electrode for highly crack-resistant joint welding of steels with a higher carbon content. It is suitable for fine grained steel providing excellent toughness values at low temperatures up -60 °C, e. g. for offshore use. The special coating provides low moisture absorption (LMA type).

Field



Characteristic
basic-coated,
120 % recovery

Standards
ISO 2560-A
E 46 4 Z B 42 H5
AWS A 5.1
E 7018-1

Approvals



Materials	
Construction steels	S275 - S355
Fine-Grained steels	S275 - S460
Ship steels	A32/36, D32/36, E32/36, F32/36, A/D/E/F40
Boiler steels	P195 - P460
Pipe steels	L210 - L450
Cast steels	GE200, GE240, GP240, G20Mn5, G21Mn5
Reinforcing steels	BSt 420, BSt 500

All Weld Metal Mechanical Properties	
Heat Treatment	AW
Weld Metal Composition [%]	
C	0,07
Si	0,45
Mn	1,35
Ni	0,5
Yield Strength Re [MPa]	> 490
Tensile Strength Rm [MPa]	570-620
Elongation A5 [%]	> 24
Charpy Impact Value ISO-V [J/-40°C]	> 100

Welding Current, Packaging

Item no.	Dia./Length [mm]	Amperage [A]	kg/Pack	= Piece/Pack	kg/1000 Pc.
00.140.253	2,50/350	90 - 110	4,6	196	23,5
00.140.323	3,25/350	110 - 150	4,5	110	40,9
00.140.324	3,25/450	110 - 150	6,0	115	52,2
00.140.403	4,00/350	140 - 180	4,8	86	55,8
00.140.404	4,00/450	140 - 180	6,0	82	73,2
00.140.504	5,00/450	180 - 220	6,0	54	111,1
00.140.604	6,00/450	210 - 270	6,0	39	153,8



[kjellberg.de](http://www.kjellberg.de)

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