

Processing information

Welding positions:



Polarity:



Application

High-efficiency electrode, especially designed for fillet welds, filler and cover passes in welding positions PA and PB in engineering, ship and bridge building. It allows very cost-efficient welding due to a high run-out length. It is characterised by a smooth arc, very clean seam surfaces and self-lifting slag.

Field



Characteristic
rutile-coated,
160 % recovery

Standards

ISO 2560-A
E42 0 Z RR 53
AWS A 5.1
E 7024

Approvals



Materials	
Construction steels	S235 - S355
Ship steels	A, B, D, A32/36, D32/36
Boiler steels	P195 - P275
Pipe steels	L210 - L245
Cast steels	GE200, GE240, GP240, G20Mo5
Reinforcing steels	BSt 420, BSt 500

All Weld Metal Mechanical Properties				
Heat Treatment				AW
Weld Metal Composition [%]				
C	Si	Mn	Ni	
0,09	0,4	0,9	0,7	
Yield Strength Re [MPa]				> 440
Tensile Strength Rm [MPa]				510-560
Elongation A5 [%]				> 22
Charpy Impact Value ISO-V [J/0°C]				> 47

Welding Current, Packaging

Item no.	Dia./Length [mm]	Amperage [A]	kg/Pack	= Piece/Pack	kg/1000 Pc.
00.820.324	3,25/450	110 - 150	6,0	88	68,2
00.820.404	4,00/450	140 - 190	5,6	55	101,8
00.820.504	5,00/450	180 - 230	6,0	38	157,9



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