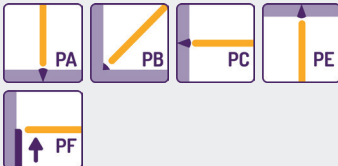


### Processing information

Welding positions:



Polarity:



### Application

Electrode for welding unalloyed and low-alloyed steel. It is especially suitable for welding thin sheets and thin-walled pipes and profiles. The electrode is characterised by fine drop transfer, low spatter, very finely rippled seam surfaces without undercutting and easy slag removal. Ignition, re-ignition and welding is also possible with low current. The arc is smooth and stable.

### Field



**Characteristic  
rutile-basic-coated**

**Standards**  
**ISO 2560-A**  
**E42 0 RB 12**  
**AWS A 5.1**  
**E 6013**

### Approvals



Materials	
Construction steels	S235 - S355
Fine-Grained steels	S275 - S355
Ship steels	A, B, D, A32/36, D32/36
Boiler steels	P195 - P355
Pipe steels	L210 - L360
Cast steels	GE200, GE240, GP240, G20Mo5, G21Mn5
Reinforcing steels	BSt 420, BSt 500

All Weld Metal Mechanical Properties	
Heat Treatment	AW
Weld Metal Composition [%]	
C	Si Mn
0,1	0,25 0,5
Yield Strength Re [MPa]	> 440
Tensile Strength Rm [MPa]	510-560
Elongation A5 [%]	> 22
Charpy Impact Value ISO-V [J/0°C]	> 60

### Welding Current, Packaging

Item no.	Dia./Length [mm]	Amperage [A]	kg/Pack	= Piece/Pack	kg/1000 Pc.
00.400.202	2,00/250	60 - 80	1,6	170	10,0
00.400.253	2,50/350	80 - 100	4,6	226	20,4
00.400.323	3,25/350	110 - 140	4,6	131	35,1
00.400.403	4,00/350	130 - 170	4,6	90	51,1



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