

Processing information

Re-drying: 300 – 350 °C/2 h
(if required)

Welding positions:



Polarity:



Soft Annealing:
780 – 820 °C, 3 – 5 h, Furnace cooling

Hardening:
1.000 – 1.050 °C, Quenching in oil

When surfacing crack-sensitive materials preheating at min. 350 °C necessary, eventually buffering (single layer) with FINOX 4370 AC.

Application

Electrode for tough-hard, impact-resistant and abrasion-resistant surfacings on unalloyed and low-alloyed metals of higher strength. This rod electrode is especially suitable for surfacings on machine parts, digging teeth, blow bars, scrapers, conveyor screws, mill hammers, mixer arms, crushing jaws and cones, etc. The weld metal is workable by grinding only and can be softannealed and hardened.

All Weld Metal Mechanical Properties

Weld Metal Composition [%]

| C | Si | Mn | Cr | Mo | V |
|-----|----|-----|-----|-----|-----|
| 0,5 | 1 | 0,5 | 7,5 | 0,5 | 0,5 |

Hardness [HB]

| | |
|-----------|---------|
| As-welded | 57 – 60 |
|-----------|---------|

Field



**Characteristic
rutile-coated**

**Standards
DIN EN 14700
E Z Fe6
DIN 8555
E 6-UM-60 P**

Welding Current, Packaging

| Item no. | Dm./Länge [mm] | Amperage [A] | kg/Pack | ≈ Piece/Pack | kg/1000 Pc. |
|------------|----------------|--------------|---------|--------------|-------------|
| 00.623.253 | 2,50/350 | 80 - 110 | 5,0 | 239 | 20,9 |
| 00.623.324 | 3,25/450 | 110 - 140 | 6,0 | 128 | 46,9 |
| 00.623.404 | 4,00/450 | 130 - 170 | 6,0 | 86 | 69,8 |
| 00.623.504 | 5,00/450 | 170 - 210 | 6,0 | 56 | 107,1 |



www.kjellberg.de

Kjellberg Finsterwalde
Elektroden und
ZusatzMaterials GmbH
Ludwig-Erhard-Str. 12
03238 Finsterwalde
Germany

Copyright © 2018 | E18-12-66E
Kjellberg Finsterwalde

+49 3531 50768-0

✉ elektrode@kjellberg.de