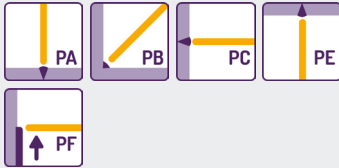


Processing information

Re-drying: 300 – 350 °C/2 h

Welding positions:



Polarity:



Whether preheating is required depends on the base material.

Application

Special electrode for joint welding of austenitic-ferritic joints as well as for joining stainless chromium steel, high-manganese steel, chromium-nickel-manganese steel and armoured steel.

Field



Characteristic
rutile-coated,
core wire-alloyed

Standards

ISO 3581-A
E 20 10 3 R 12

AWS A 5.4
E 308 Mo-16

Material no.

1.4431

All Weld Metal Mechanical Properties

Heat Treatment	AW				
Structure	Austenite with approx. 20 % Ferrite				
Weld Metal Composition [%]					
C	Si	Mn	Cr	Ni	Mo
0,04	0,5	0,8	20	10	3
Yield Strength Rp 0,2 [MPa]		> 400			
Tensile Strength Rm [MPa]		> 600			
Elongation A5 [%]		> 25			
Charpy Impact Value ISO-V [J/RT]		> 60			

Welding Current, Packaging

Item no.	Dm./Länge [mm]	Amperage [A]	kg/Pack	≈ Piece/Pack	kg/1000 Pc.
00.707.250	2,50/300	80 - 100	4,0	219	18,3
00.707.323	3,25/350	100 - 130	5,0	136	36,8
00.707.403	4,00/350	120 - 160	5,0	91	54,9



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