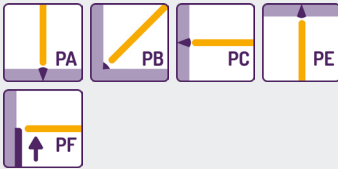


### Processing informatione

Whether preheating is required depends on the base material, otherwise not necessary. Interpass temperature max. 150 °C.

Re-drying: 250 - 300 °C/2 h  
(if required)

Welding positions:



Polarity:



### Application

Electrode for joint welding on unstabilised and stabilised austenitic, chemically stable chromium-nickel steel at working temperatures of up to 400 °C as well as for corrosion-resistant chromium steel and claddings of similar alloys.

### Field



**Characteristic**  
**basic-coated,**  
**core wire-alloyed**

**Standards**  
**ISO 3581-A**  
**E 19 9 Nb B 22**  
**AWS A 5.4**  
**E 347-15**

**Material no.**  
**1.4551**

### Materials

|               |                  |               |                                    |
|---------------|------------------|---------------|------------------------------------|
| <b>1.4301</b> | X 5 CrNi 18-10   | <b>1.4550</b> | X 6 CrNiNb 18-10                   |
| <b>1.4306</b> | X 2 CrNi 19-11   | <b>1.4552</b> | GX 5 CrNiNb 19-11                  |
| <b>1.4311</b> | X 2 CrNiN 18-10  | -             | AISI 304<br>AISI 304L              |
| <b>1.4541</b> | X 6 CrNiTi 18-10 | -             | AISI 304LN<br>AISI 321<br>AISI 347 |

### All Weld Metal Mechanical Properties

|   |                                    |       |      |    |     |
|---|------------------------------------|-------|------|----|-----|
| <b>Heat Treatment</b>                   | AW                                 |       |      |    |     |
| <b>Structure</b>                        | Austenite with approx. 8 % ferrite |       |      |    |     |
| <b>Weld Metal Composition [%]</b>       |                                    |       |      |    |     |
| C                                       | Si                                 | Mn    | Cr   | Ni | Nb  |
| 0,04                                    | 0,5                                | 1,2   | 19,5 | 10 | 0,5 |
| <b>Yield Strength Rp 0,2 [MPa]</b>      |                                    | > 350 |      |    |     |
| <b>Tensile Strength Rm [MPa]</b>        |                                    | > 550 |      |    |     |
| <b>Elongation A5 [%]</b>                |                                    | > 25  |      |    |     |
| <b>Charpy Impact Value ISO-V [J/RT]</b> |                                    | > 75  |      |    |     |

### Welding Current, Packaging

| Item no.          | Dm./Länge [mm] | Amperage [A] | kg/Pack | = Piece/Pack | kg/1000 Pc. |
|-------------------|----------------|--------------|---------|--------------|-------------|
| <b>00.705.250</b> | 2,50/300       | 70 - 100     | 4,0     | 266          | 15,0        |
| <b>00.705.323</b> | 3,25/350       | 100 - 130    | 5,0     | 170          | 29,5        |



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