

#### Processing information

When welding heat-resistant Cr-steels preheating and interpass temperature of 200 to 300 °C is recommended, otherwise no preheating (attention: brittleness properties of base material). Post weld heat treatment only in dependence on base material necessary.

Re-drying: 300 - 350 °C/2 h

Welding positions:



Polarity:



#### Application

Electrode for joint welding and surfacing on heat-resistant chromium and chromiumnickel steel and cast steel of the same or similar alloy at working temperatures of up to 1,100 °C and rustless, corrosion-resistant molybdenum-free chromium(-nickel) steel and cast steel. The ferriteic-austenitic weld metal is scale-resistant at air and oxidising (combustion) gases up to 1,100 °C and shows good resistance against reducing, sulphur-containing (combustion) gases.

#### Field



**Characteristic**  
**rutile-coated, alloyed**  
**through coating**

**Standards**  
**ISO 3581-A**  
**E 25 4 R 52**

**Material no.**  
**1.4820**

#### Materials

<b>1.4710</b>	GX 30 CrSi7	<b>1.4742</b>	X 10 CrAlSi18
<b>1.4713</b>	X 10 CrAlSi7	<b>1.4762</b>	X 10 CrAl 25
<b>1.4724</b>	X 10 CrAlSi13	<b>1.4821</b>	X 15 CrNiSi 25-4
<b>1.4740</b>	GX 40 CrSi17	<b>1.4823</b>	GX 40 CrNiSi 27-4

#### All Weld Metal Mechanical Properties

<b>Heat Treatment</b>	AW			
<b>Structure</b>	Ferrite with approx. 20 % austenite			
<b>Weld Metal Composition [%]</b>				
C	Si	Mn	Cr	Ni
0,06	0,8	1	26	4,5
<b>Yield Strength Rp 0,2 [MPa]</b>		> 500		
<b>Tensile Strength Rm [MPa]</b>		> 700		
<b>Elongation A5 [%]</b>		> 15		
<b>Charpy Impact Value ISO-V RT [J]</b>		> 20		
<b>Hardness [HB]</b>		180		

#### Welding Current, Packaging

Item no.	Dia./Length [mm]	Amperage [A]	kg/Pack	= Piece/Pack	kg/1000 Pc.
<b>00.711.253</b>	2,50/350	80 - 110	5,0	169	29,6
<b>00.711.323</b>	3,25/350	110 - 140	5,0	103	48,5
<b>00.711.403</b>	4,00/350	130 - 170	5,0	68	73,5



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