Kjellberg® FINSTERWALDE

STICK ELECTRODES, HEAT-RESISTANT

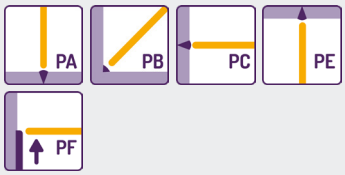
FINOX 4829 AC

Processing information

Wheter preheating is required depends on the base material, otherwise not necessary. Interpass temperature max. 200 °C.

Re-drying: 300 - 350 °C/2 h

Welding positions:



Polarity:

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Application

Electrode for joint welding and surfacing on heat-resistant steel and cast steel of the same or similar alloy at working temperatures of up to 950 °C. This stick electrode is especially suitable for the stainless steel X 15 CrNiSi 20 12 (1.4828).

Field

Characteristic

rutile-coated, core wire-alloyed

Standards

ISO 3581-A
E 22 12 R 32

AWS A 5.4
E 309-17

Material no.

1.4829

Materials

1.4710	GX 30 CrSi7	**1.4826**	GX 40 CrNiSi 22-10
1.4713	X 10 CrAlSi7	**1.4828**	X 15 CrNiSi 20-12
1.4724	X 10 CrAlSi13	**1.4833**	X 12 CrNi 23-13
1.4740	GX 40 CrSi17	**1.4878**	X 8 CrNiTi 18-10
1.4742	X 10 CrAlSi18	**-**	AISI 309

All Weld Metal Mechanical Properties

Heat Treatment	AW
Structure	Austenite with approx. 7 % ferritet
Weld Metal Composition [%]	

C	Si	Mn	Cr	Ni
0,1	0,8	0,7	22,5	12,5

Yield Strength Rp 0,2 [MPa]	> 350
Tensile Strength Rm [MPa]	> 550
Elongation A5 [%]	> 30
Charpy Impact Value ISO-V RT [J]	> 55

Welding Current, Packaging

Item no.	Dia./Length [mm]	Amperage [A]	kg/Pack	≈ Piece/Pack	kg/1000 Pc.
00.717.250	2,50/300	70 - 100	4,0	222	18,1
00.717.323	3,25/350	100 - 140	5,0	137	36,5
00.717.403	4,00/350	130 - 170	5,0	92	54,3

THE ORIGINAL MADE IN GERMANY SINCE 1920

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