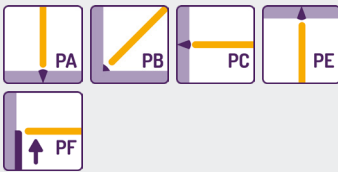


Processing information

When welding heat-resistant Cr-steels preheating and interpass temperature of 200 to 400 °C is recommended, otherwise no preheating. Post weld heat treatment only in dependence on base material necessary.

Re-drying: 300 - 350 °C/2 h

Welding positions:



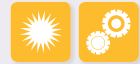
Polarity:



Application

Electrode for joint welding and surfacing on heat-resistant chromium-nickel steel and cast steel of the same or similar grade at working temperatures of up to 1,200 °C, for tough joints, intermediate and filler layers when welding chromium steel and cast steel. Further, it is suitable for joining unalloyed and low-alloyed steel and cast steel or stainless and heat-resistant chromium steel and cast steel with austenitic steel and cast steel at working temperatures of up to 300 °C. The weld metal does not have sufficient resistance against reducing, sulphur-containing and carburising gases. A cover layer with Finox 4820 AC should be applied in these cases.

Field



Characteristic
rutile-coated,
core wire-alloyed

Standards
ISO 3581-A
E 25 20 R 12

AWS A 5.4
= E 310-16

Material no.
1.4842

Materials

1.4710	GX 30 CrSi 7	1.4833	X 12 CrNi 23-13
1.4713	X 10 CrAlSi 7	1.4840	GX 15 CrNi 25-20
1.4724	X 10 CrAlSi13	1.4841	X 15 CrNiSi 25-21
1.4742	X 10 CrAlSi18	1.4845	X 8 CrNi 25-21
1.4762	X 10 CrAlSi 25	1.4846	X 40 CrNi 25-21
1.4828	X 15 CrNiSi 20-12	-	AISI 310, 310S, 314

All Weld Metal Mechanical Properties

Heat Treatment	AW			
Structure	Austenite			
Weld Metal Composition [%]				
C	Si	Mn	Cr	Ni
0,12	0,7	3	25	20
Yield Strength Rp 0,2 [MPa]		> 350		
Tensile Strength Rm [MPa]		> 550		
Elongation A5 [%]		> 30		
Charpy Impact Value ISO-V RT [J]		> 70		

Welding Current, Packaging

Item no.	Dia./Length [mm]	Amperage [A]	kg/Pack	= Piece/Pack	kg/1000 Pc.
00.712.250	2,50/300	80 - 100	4,0	212	18,9
00.712.323	3,25/350	110 - 140	5,0	130	38,5
00.712.403	4,00/350	130 - 170	5,0	89	56,2



[kjellberg.de](http://www.kjellberg.de)

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