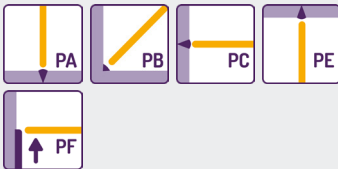


Processing information

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 of base material necessary.

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

Welding positions:



Polarity:

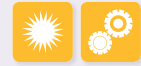


Application

Electrode for joint welding and surfacing on heat-resistant chromium-nickel steel and cast steel of the same or similar alloy at working temperatures of up to 1200 °C, for tough joints, intermediate and filler layers when welding chromium steel and cast steel. Further, this electrode 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
basic-coated,
core wire-alloyed

Standards
ISO 3581-A
E 25 20 B 22

AWS A 5.4
E 310-15

Material no.
14842

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 |
| 0,1 | 0,8 | 2,5 | 25 | 20 |
| Yield Strength Rp 0,2 [MPa] | | > 350 | | |
| Tensile Strength Rm [MPa] | | > 550 | | |
| Elongation A5 [%] | | > 30 | | |
| Charpy Impact Value ISO-V RT [J] | | > 80 | | |

Welding Current, Packaging

| Item no. | Dm./Länge [mm] | Amperage [A] | kg/Pack | ≈ Piece/Pack | kg/1000 Pc. |
|-------------------|----------------|--------------|---------|--------------|-------------|
| 00.713.250 | 2,50/300 | 80 - 100 | 4,0 | 266 | 15,0 |
| 00.713.323 | 3,25/350 | 100 - 130 | 5,0 | 170 | 29,4 |
| 00.713.403 | 4,00/350 | 120 - 160 | 5,0 | 113 | 44,2 |



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