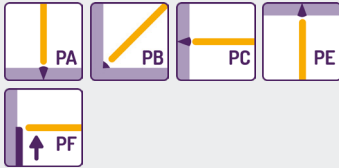


Processing information

Re-drying: 250 – 300 °C/2 h

Welding positions:



Polarity:



Whether preheating is required depends on the base material.

Application

Nickel-base electrode for high-quality crack-resistant joint welding and plating on identical nickelchromium and nickel-chromium-ferrous alloys, (heat-resistant) Cr and CrNi (Mo, N) steels and nickel-alloyed cold-tough pressure tank steel. For austenite-ferrite joints (e.g. 1.4583 with 16Mo3) Usable at working temperatures between -196 °C and 800 °C (in case of sulphurous atmosphere only up to 500 °C).

This electrode is very well suited for fixed position welding. The fully austenitic weld metal is chemically stable, cold-tough, heat-resistant, scale-resistant up to 1,000 °C and resistant against embrittlement.

Field



**Characteristic
basic-coated**

**Standards
ISO 14172
E Ni 6082
(NiCr 20 Mn 3 Nb)**

**AWS A 5.11
= E NiCrFe-3**

**Material no.
2.4648**

Materials

1.4876	X 10 NiCrAlTi 32-21	- Alloy 600
2.4631	NiCr 20 TiAl	- Alloy 800
2.4669	NiCr 15 Fe 7 TiAl	- Alloy 80A
2.4816	NiCr 15 Fe	- Alloy X750

All Weld Metal Mechanical Properties

Heat Treatment	AW						
Structure	Austenite						
Weld Metal Composition [%]							
C	Si	Mn	Cr	Mo	Nb	Fe	Ni
0,03	0,4	5	19	1,5	2,2	3	B
Yield Strength Rp 0,2 [MPa]		> 400					
Tensile Strength Rm [MPa]		> 620					
Elongation A5 [%]		> 35					
Charpy Impact Value ISO-V [J/RT]		> 90					

Welding Current, Packaging

Item no.	Dm./Länge [mm]	Amperage [A]	kg/Pack	≈ Piece/Pack	kg/1000 Pc.
00.765.250	2,50/300	70 - 100	4,0	228	17,0
00.765.323	3,25/350	100 - 130	5,0	153	32,5
00.765.403	4,00/350	120 - 160	5,0	104	52,6



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