

Processing informatione

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

Welding positions:



Polarity:



To avoid cracks preheating up to min.
500 °C, slow down cooling necessary.

Application

Electrode for highly wear-resistant surfacings on unalloyed and low-alloyed metals of higher strength, especially when heavily abrasion-loaded and exposed to moisture. This stick electrode is especially suitable for surfacings on mixer and agitator arms, crushing mills, conveyor screws, guideways, slides and skids. Surfacing should be applied in two layers only. For higher surfacings it is recommended to fill them up with Fidur 8/200 or FINOX 4370 AC/B beforehand. The rustless ledeburitic weld metal is workable by grinding only.

Field



Characteristic
rutile-coated,
160 % recovery

Standards
DIN EN 14700
E Fe14
DIN 8555
E 10-UM-60 GR

All Weld Metal Mechanical Properties

Weld Metal Composition [%]

C	Si	Mn	Cr	other
3,8	0,9	0,4	33	≈ 2

Hardness [HRC]

As-welded	57 – 60
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Welding Current, Packaging

Item no.	Dm./Länge [mm]	Amperage [A]	kg/Pack	≈ Piece/Pack	kg/1000 Pc.
00.615.253	2,50/350	90 – 120	5,0	154	32,5
00.615.323	3,25/350	120 – 160	5,0	94	53,2
00.615.404	4,00/450	150 – 190	6,0	57	105,3
00.615.504	5,00/450	180 – 240	6,0	37	162,2



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