

Processing information

Re-drying: 300 - 350 °C/2 h

Welding positions:



Polarity:



When surfacing crack-sensitive materials preheating at min. 350 °C necessary, eventually buffering (single layer) with FINOX 4370 AC.

Application

Electrode for tough-hard, impact-resistant and abrasion-resistant surfacings on unalloyed and low-alloyed metals of higher strength. It is suitable for surfacings on digging teeth, blow bars, scrapers, screw conveyors, mill hammers, mixer arms, crusher jaws, cone crushers etc. The surfacings are machinable by grinding only.

Field



**Characteristic
basic-coated**

**Standards
DIN EN 14700
E Fe6
DIN 8555
E 6-UM-55**

All Weld Metal Mechanical Properties

Weld Metal Composition [%]

C	Si	Mn	Cr
0,6	0,3	1	5

Hardness [HRC]

As-welded	52 - 55
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Welding Current, Packaging

Item no.	Dm./Länge [mm]	Amperage [A]	kg/Pack	= Piece/Pack	kg/1000 Pc.
00.651.324	3,25/450	110 - 140	6,0	134	44,8
00.651.404	4,00/450	140 - 180	6,0	88	68,2
00.651.504	5,00/450	170 - 220	6,0	57	105,3



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Kjellberg Finsterwalde
Elektroden und
ZusatzMaterials GmbH
Ludwig-Erhard-Str. 12
03238 Finsterwalde
Germany

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Kjellberg Finsterwalde

 +49 3531 50768-0

 elektrode@kjellberg.de