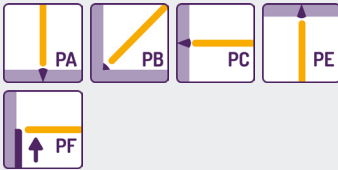


Processing information

Re-drying: 300 - 350 °C/2 h

Welding positions:



Polarity:



Application

Double coated basic electrode for high quality and crack resistant joint welding in machine construction, steel fabrication, boiler construction. It is characterised by good welding properties in fixed positions.

Field



Characteristic
basic-coated,
double-coated

Standards
ISO 2560-A
E 46 3 B 22 H5
AWS A 5.1
E 7018-1

Approvals



Materials

Construction steels	S275 - S355
Fine-Grained steels	S275 - S460
Ship steels	A32/36, D32/36, E32/36, F32/36, A/D/E40
Boiler steels	P195 - P460
Pipe steels	L210 - L450
Cast steels	GE200, GE240, GP240, G20Mn5, G21Mn5
Reinforcing steels	BSt 420, BSt 500

All Weld Metal Mechanical Properties

Heat Treatment	AW	
Weld Metal Composition [%]		
C	Si	Mn
0,07	0,6	1
Yield Strength Re [MPa]	> 460	
Tensile Strength Rm [MPa]	550-600	
Elongation A5 [%]	> 25	
Charpy Impact Value ISO-V [J/-20°C]	> 70	

Welding Current, Packaging

Item no.	Dia./Length [mm]	Amperage [A]	kg/Pack	= Piece/Pack	kg/1000 Pc.
00.150.253	2,50/350	80 - 100	4,3	198	21,7
00.150.323	3,25/350	100 - 130	4,5	127	35,4
00.150.404	4,00/450	120 - 160	5,6	82	68,3



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