

Processing information

Polarity:



Impulsive movements of the electrode support the molten metal to be driven out of the kerf. When processing horizontal workpieces, it is best to use a flat angle of attack in cutting direction. Moist electrodes should be dried for approx. 30 minutes at 70 °C. In enclosed rooms it is necessary to suction the welding fumes.

Application

Coated stick electrode for cutting all unalloyed and alloyed steel grades as well as non-ferrous metal, cast steel and cast iron. During the processing, the oxidation of the coating material creates a high gas pressure thus causing the liquid base material to be driven out of the kerf. The result is a smooth and clean cut. The molten and adherent base material can be easily removed with a chipping hammer. The electrode is suited for cost-efficient cutting and hole piercing. Due to the small demand of technical equipment and the processing without auxiliary materials the electrode is excellently suited for the use at assembly workplaces, construction sites, in scrap processing, etc. For gouging and notching we recommend our stick electrode KJELGOUGE.

Field



use

Electrode for Cutting

Materials

Metallic Materials

Welding Current, Packaging

Item no.	Dm./Länge [mm]	Amperage [A]	kg/Pack	≈ Piece/Pack	kg/1000 Pc.
00.991.324	3,25/450	110 - 150	6,0	130	46,2
00.991.404	4,00/450	140 - 190	6,0	87	69,0
00.991.504	5,00/450	180 - 230	6,0	55	109,1



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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