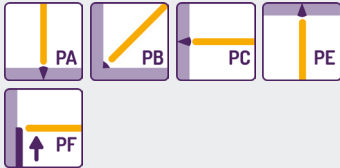


### Processing information

Re-drying: 300 - 350 °C/2 h

Welding positions:



Polarity:



### Application

With a molybdenum content of 0.4 % in the weld metal, this electrode is especially suitable for steel 16Mo3. Typical application areas are boiler, container and pipeline construction and at working temperatures of up to 520 °C.

### Field



**Characteristic  
basic-coated**

### Standards

**ISO 3580-A  
E Mo B 42**

**AWS A 5.5  
E 7018-A1**

### Approvals



### Materials

<b>Construction steels</b>	S275 bis S355
<b>Fine-Grained steels</b>	S275 bis S460
<b>Boiler steels</b>	P195 bis P460, 16Mo3
<b>Pipe steels</b>	L210 bis L450
<b>Cast steels</b>	GE200 , GE240, GP 240, G20Mo5

### All Weld Metal Mechanical Properties

<b>Heat Treatment</b>	SR		
<b>Weld Metal Composition [%]</b>			
C	Si	Mn	Mo
0,08	0,4	1,0	0,4
<b>Yield Strength Re [MPa]</b>		> 450	
<b>Tensile Strength Rm [MPa]</b>		540-590	
<b>Elongation A5 [%]</b>		> 24	
<b>Charpy Impact Value ISO-V [J/-10 °C]</b>		> 80	

### Welding Current, Packaging

Item no.	Dia./Length [mm]	Amperage [A]	kg/Pack	= Piece/Pack	kg/1000 Pc.
<b>00.470.253</b>	2,50/350	70 - 100	4,3	192	22,4
<b>00.470.323</b>	3,25/350	110 - 150	4,8	139	34,5
<b>00.470.403</b>	4,00/350	140 - 180	4,7	90	52,2



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