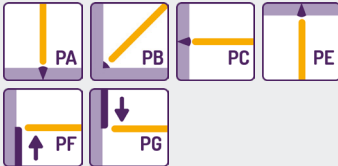


Processing information

Welding positions:



Polarity:



Application ■■■

General purpose electrode which is easy to handle and suitable for versatile applications in engineering, shipbuilding and pipeline construction. Excellent welding properties in all positions, especially in vertical down position. With this electrode the welding result shows perfect seam surfaces, self-lifting slag and low spraying loss. The rod electrode has a good re-ignitability.

Field



Characteristic
rutile-cellulosic-coated

Standards

ISO 2560-A
E38 0 RC 11

AWS A 5.1
E 6013

Approvals



Materials	
Construction steels	S235 - S355
Ship steels	A, B, D, A32/36, D32/36
Boiler steels	P195 - P275
Pipe steels	L210 - L245
Cast steels	GE200, GE240, GP240, G20Mo5
Reinforcing steels	BSt 420

All Weld Metal Mechanical Properties	
Heat Treatment	AW
Weld Metal Composition [%]	
C	Si Mn
0,08	0,3 0,6
Yield Strength Re [MPa]	> 380
Tensile Strength Rm [MPa]	510 - 560
Elongation A5 [%]	> 22
Charpy Impact Value ISO-V [J/0°C]	> 60

Welding Current, Packaging

Item no.	Dia./Length [mm]	Amperage [A]	kg/Pack	≈ Piece/Pack	kg/1000 Pc.
00.905.202	2,00/250	50 - 80	1,6	170	9,4
00.905.253	2,50/350	80 - 110	4,8	247	19,4
00.905.323	3,25/350	110 - 140	5,0	162	30,9
00.905.403	4,00/350	130 - 170	5,0	106	47,2
00.905.404	4,00/450	130 - 170	6,5	107	60,8
00.905.504	5,00/450	170 - 210	6,5	70	92,9



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