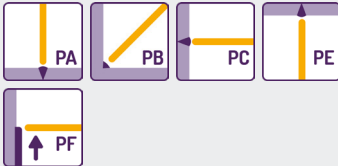


Processing information

Welding positions:



Polarity:



Application

Electrode for a wide range of applications in engineering, pipeline and container construction and ship building. It is characterised by excellent ignition, a smooth arc and low spatter. The electrode provides a finely rippled seam surface, flat concave fillets and self-lifting slag.

Field



**Characteristic
rutile-coated**

Standards
ISO 2560-A
E35 0 RR 12
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	0,25	0,4
Yield Strength Re [MPa]	> 360	
Tensile Strength Rm [MPa]	450 - 550	
Elongation A5 [%]	> 22	
Charpy Impact Value ISO-V [J/0°C]	> 55	

Welding Current, Packaging

Item no.	Dia./Length [mm]	Amperage [A]	kg/Pack	≈ Piece/Pack	kg/1000 Pc.
00.240.253	2,50/350	80 - 100	4,8	230	20,9
00.240.323	3,25/350	100 - 130	4,8	137	35,0



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