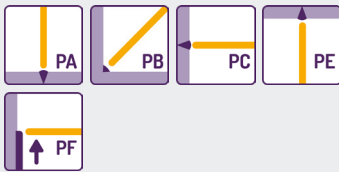


Processing information

Preheating and interpass temperature from 250 up to 350 °C depending on base material, shape of material and thickness.

Welding positions:



Polarity:



Tempering: min. 0.5 h at 700 °C
down-cooling at resting air

Annealing: 0.5 h at 930 to 950 °C
down-cooling by air, afterwards 0.5 h
at 700 °C down-cooling by air

Application

Electrode for joint welding on boiler and pipe steel as well as on similar chromium-molybdenum-alloyed, pressure-hydrogen-resistant steel, especially for the steel 13CrMo4-5 at working temperatures of up to 550 °C. It is in particular suitable for root welding. Further, this rod electrode is suitable for joint welding and surfacing on similar-alloyed case-hardened and heat-treated steel.

Field



Characteristic
rutil-coated

Standards
**ISO 3580-A
E CrMo 1 R 12
AWS A 5.5
E 8013-G**

Materials

1.7218	25 CrMo 4	1.7335	13 CrMo 4-5
1.7218	G 25 CrMo 4	1.7337	16 CrMo 4-4
1.7254	20 CrMo 4	1.7350	22 CrMo 4-4
1.7258	24 CrMo5	1.7354	G22 CrMo 5-4
1.7262	15 CrMo 5		

All Weld Metal Mechanical Properties

Heat Treatment	SR			
Weld Metal Composition [%]				
C	Si	Mn	Cr	Mo
0,1	0,3	0,6	1,1	0,5
Yield Strength Re [MPa]		> 360		
Tensile Strength Rm [MPa]		510-540		
Elongation A5 [%]		> 20		
Charpy Impact Value ISO-V [J/+20 °C]		> 47		

Welding Current, Packaging

Item no.	Dia./Length [mm]	Amperage [A]	kg/Pack	= Piece/Pack	kg/1000 Pc.
00.489.253	2,50/350	90 - 110	4,8	228	21,1
00.489.323	3,25/350	110 - 150	4,8	142	33,8



[kjellberg.de](http://www.kjellberg.de)

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