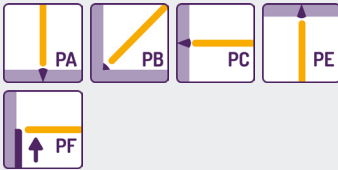


### Processing information

Re-drying: 300 - 350 °C/2 h

Welding positions:



Polarity:



### Application

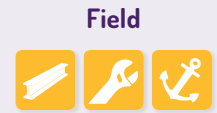
Due to its excellent welding properties and easy handling, the double coated stick electrode DUOWELD is suitable as a universal welding filler metal in all areas of industry and trade. The special structure of the electrode with two coating materials with different properties combines the advantages of a rutile coating with the high strength values of basic electrodes. A concentrated and stable arc is the basis for the outstanding for the excellent suitability for constrained layers and for X-ray safe root layers.

Materials	
Construction steels	S235 - S355
Fine-Grained steels	S275 - S420
Ship steels	A32/36, D32/36, E32/36, F32/36, A/D
Boiler steels	P195 - P355
Pipe steels	L210 - L360
Cast steels	GE200, GE240, GP240, G21Mn5
Reinforcing steels	BSt 420, BSt 500

All Weld Metal Mechanical Properties	
Heat Treatment	AW
Weld Metal Composition [%]	
C	Si Mn
0,08	0,5 1,1
Yield Strength Re [MPa]	> 430
Tensile Strength Rm [MPa]	> 490
Elongation A5 [%]	> 25
Charpy Impact Value ISO-V [J/-30°C]	> 60

### Welding Current, Packaging

Item no.	Dia./Length [mm]	Amperage [A]	kg/Pack	= Piece/Pack	kg/1000 Pc.
00.133.253	2,50/350	70 - 100	4,3	207	20,8
00.133.323	3,25/350	90 - 130	4,3	122	36,9
00.133.404	4,00/450	110 - 160	5,6	81	69,1



### Characteristic

**double-coated,  
basic-coated with  
non-basic  
components**

Standards  
**ISO 2560-A  
E 42 3 B 12 H10  
AWS A 5.1  
E 7016**

### Approvals

Applied for. Ask us to find out the current status



.kjellberg.de

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