

Processing information

Re-drying: 300 – 350 °C/2 h
(if required)

Welding positions:



Polarity:



Soft Annealing:

800 – 840 °C, 2–4 h Furnace cooling

Hardening: 1060 – 1120 °C, Quenching
in oil, salt-bath or compressed air

Tempering: ≈ 3 h, Temperature acc.
to hardness

350 °C ≈ 48 HRC Air cooling

450 °C ≈ 49 HRC Air cooling

560 °C ≈ 52 HRC Air cooling

To avoid hot cracking preheating up
to 400 °C and slow cooling necessary.
Welding with lowest heat input recom-
mended when material thicknesses
are different, otherwise stresses and
cracks possible.

Application

Electrode for repairs of hot-working tools from
similar steels, for example forging dies, press
jacks, hotdraw rings, hot-cutting and hot-
upsetting tools from unalloyed and low-alloyed
steel of higher strength.

Field



**Characteristic
rutile-coated**

**Standards
DIN EN 14700
E Fe3
DIN 8555
E 3-UM-50 T**

All Weld Metal Mechanical Properties

Weld Metal Composition [%]

C	Si	Mn	Cr	W	V
0,25	0,3	0,5	2,5	4	0,6

Hardness [HRC]

As-welded	≈ 47
After tempering	≈ 50

Welding Current, Packaging

Item no.	Dm./Länge [mm]	Amperage [A]	kg/Pack	≈ Piece/Pack	kg/1000 Pc.
00.611.323	3,25/350	110 - 140	5,0	124	40,3
00.611.403	4,00/350	140 - 180	5,0	79	63,3



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