

Processing information

Re-drying: 300 – 350 °C/2 h

Welding positions:



Polarity:



High-manganese steels should be cold-welded, if possible. Larger components need to be cooled. Intermediate layer temperature is max. 250 °C. Massive components from unalloyed, crack-sensitive steels with higher carbon content need to be pre-heated to 250–350 °C.

Application

Electrode for surfacing on parts which are subject to heavy impact wear and sliding wear. For example: consumables in minerals processing, digging teeth, blow bars, crusher jaws but also railways, switches, centrepieces. Particularly suited for base materials from high-manganese steels, but also for unalloyed and low-alloyed steels. The weld metal is work-hardenable. It is still machinable after welding.

Field



**Characteristic
basic-coated**

**Standards
DIN EN 14700
E Z Fe9
DIN 8555
E 7-UM-250 KP**

All Weld Metal Mechanical Properties

Weld Metal Composition [%]

C	Mn	Cr	Ni
0,7	13	4,5	4

Hardness [HB]

As-welded	200 - 250
workhardened	400 - 450

Welding Current, Packaging

Item no.	Dm./Länge [mm]	Amperage [A]	kg/Pack	≈ Piece/Pack	kg/1000 Pc.
00.647.323	3,25/350	110 - 150	5,0	134	37,3
00.647.404	4,00/450	140 - 180	6,0	83	72,3
00.647.504	5,00/450	180 - 220	6,0	53	113,2



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