

Processing information

Re-drying: 300 – 350 °C/2 h

Welding positions:



Polarity:



Preheating and interpass temperature – depending on base material, shape and size of work piece up to 450 to 600 °C.

Application

Cobalt-based electrode for surfacing against corrosion, oxidation, moderate abrasion, heavy cavitation and erosion at high temperatures. The weld metal has very high thermal shock resistance. Excellent resistance against metal sliding abrasion. Usable for forging dies, high-temperature mixers, gas turbines and starting valves of combustion engines. The weld metal is work-hardenable.

Field



**Characteristic
rutile-coated**

**Standards
DIN EN 14700
E Co1
DIN 8555
E 20-UM-35 CTZ**

All Weld Metal Mechanical Properties

Weld Metal Composition [%]

C	Mn	Cr	Mo	Ni	Co
0,3	1	30	5,5	3,5	B

Hardness [HRC]

at RT	≈ 35
at 300 °C	≈ 30
at 600 °C	≈ 25

Welding Current, Packaging

Item no.	Dm./Länge [mm]	Amperage [A]	kg/Pack	= Piece/Pack	kg/1000 Pc.
00.619.323	3,25 / 350	110 – 140	5,0	140	35,7
00.619.403	4,00 / 350	130 – 170	5,0	94	53,2



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