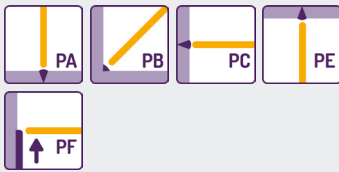


Processing information

Re-drying: 250 – 300 °C/2 h
(if required)

Welding positions:



Polarity:



Whether preheating is required depends on the ferritic base material, low heat input required, to avoid hard and brittle martensitic weld junction. Otherwise welding without preheating possible.

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

Application

Basic-coated stick electrode for joint and surface welding of dissimilar steels, heat-treatable, armour and high-manganese steels among each other and with one another, for austenitic-ferrite joints at working temperatures of up to 300 °C, for welding of steels with high carbon content and hard-to-weld steels. The weld metal is fully austenitic, corrosion-resistant, scale-resistant up to 850 °C and cold-hardenable up to a hardness of approx. 350 HB.



Characteristic

**basic-coated,
core wire-alloyed**

Standards
**ISO 3581-A
E 18 8 Mn B 22**

**AWS A 5.4
= E 307-15**

Material no.
1.4370

All Weld Metal Mechanical Properties

Heat Treatment	AW			
Structure	Austenite			
Weld Metal Composition [%]				
C	Si	Mn	Cr	Ni
0,1	0,5	6,5	19	9
Yield Strength Rp 0,2 [MPa]		> 350		
Tensile Strength Rm [MPa]		> 600		
Elongation A5 [%]		> 35		
Charpy Impact Value ISO-V [J/RT]		> 100		

Welding Current, Packaging

Item no.	Dm./Länge [mm]	Amperage [A]	kg/Pack	≈ Piece/Pack	kg/1000 Pc.
00.744.250*	2,50/300	70 - 100	4,0	267	15,0
00.744.323*	3,25/350	100 - 130	5,0	167	29,9
00.744.403*	4,00/350	120 - 160	5,0	111	45,0

* This product is not a standard stock article. All dimensions are produced only to customer order. Ask for an individual quotation.



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

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