

### Processing information

Whether preheating is required depends on the base material, otherwise not necessary. Interpass temperature max. 150 °C.

Re-drying: 300 - 350 °C/2 h

Welding positions:



Polarity:



### Application

This stainless steel electrode was especially developed for welding in vertical down position. Electrode for joint welding on low-carbon, unstabilised and stabilised, austenitic, chemically stable chromium-nickel-molybdenum steel at working temperatures of up to 400 °C. It is also suitable for corrosion-resistant chromium steel and claddings of similar alloy.

Field



**Characteristic**  
**rutile-coated,**  
**core wire-alloyed**

Standards

**ISO 3581-A**  
**E 19 12 3 L R 11**  
**AWS A 5.4**  
**E 316 L-16**

Material no.

**1.4430**

### Materials

<b>1.4401</b>	X 5 CrNiMo 17-12-2	<b>1.4435</b>	X 2 CrNiMo 18-14-3
<b>1.4404</b>	X 2 CrNiMo 17-12-2	<b>1.4436</b>	X 3 CrNiMo 17-13-3
<b>1.4406</b>	X 2 CrNiMoN 17-11-2	<b>1.4571</b>	X 6 CrNiMoTi 17-12-2
<b>1.4408</b>	GX 5 CrNiMo 19-11-2	<b>1.4580</b>	X 6 CrNiMoNb 17-12-2
<b>1.4409</b>	GX 2 CrNiMo 19-11-2	-	AISI 316 AISI 316L AISI 316 Cb AISI 316Ti
<b>1.4429</b>	X 2 CrNiMoN 17-13-3		

### All Weld Metal Mechanical Properties

<b>Heat Treatment</b>	AW				
<b>Structure</b>	Austenite with approx. 8 % ferrite				
<b>Weld Metal Composition [%]</b>					
C	Si	Mn	Cr	Ni	Nb
0,02	0,9	0,8	19,0	12,5	2,7
<b>Yield Strength Rp 0,2 [MPa]</b>		> 350			
<b>Tensile Strength Rm [MPa]</b>		> 550			
<b>Elongation A5 [%]</b>		> 30			
<b>Charpy Impact Value ISO-V [J/RT]</b>		> 60			

### Welding Current, Packaging

Item no.	Dm./Länge [mm]	Amperage [A]	kg/Pack	= Piece/Pack	kg/1000 Pc.
<b>00.706.250*</b>	2,50/300	80 - 100	4,0	236	16,9
<b>00.706.323*</b>	3,25/350	100 - 130	5,0	152	32,9

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



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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