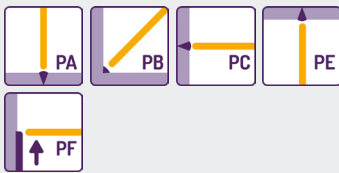


Processing information

Whether preheating is required depends on the base material, otherwise not necessary. Interpass temperature max. 200 °C.

Re-drying: 300 - 350 °C/2 h

Welding positions:



Polarity:



Application

Electrode for joint welding and surfacing on heat-resistant steel and cast steel of the same or similar alloy at working temperatures of up to 950 °C. This stick electrode is especially suitable for the stainless steel X 15 CrNiSi 20 12 (1.4828).

Field



Characteristic
rutile-coated,
core wire-alloyed

Standards
ISO 3581-A
E 22 12 R 32
AWS A 5.4
E 309-17

Material no.
1.4829

Materials

1.4710	GX 30 CrSi7	1.4826	GX 40 CrNiSi 22-10
1.4713	X 10 CrAlSi7	1.4828	X 15 CrNiSi 20-12
1.4724	X 10 CrAlSi13	1.4833	X 12 CrNi 23-13
1.4740	GX 40 CrSi17	1.4878	X 8 CrNiTi 18-10
1.4742	X 10 CrAlSi18	-	AISI 309

All Weld Metal Mechanical Properties

Heat Treatment	AW			
Structure	Austenite with approx. 7 % ferrite			
Weld Metal Composition [%]				
C	Si	Mn	Cr	Ni
0,1	0,8	0,7	22,5	12,5
Yield Strength Rp 0,2 [MPa]		> 350		
Tensile Strength Rm [MPa]		> 550		
Elongation A5 [%]		> 30		
Charpy Impact Value ISO-V RT [J]		> 55		

Welding Current, Packaging

Item no.	Dia./Length [mm]	Amperage [A]	kg/Pack	≈ Piece/Pack	kg/1000 Pc.
00.717.250	2,50/300	70 - 100	4,0	222	18,1
00.717.323	3,25/350	100 - 140	5,0	137	36,5
00.717.403*	4,00/350	130 - 170	5,0	92	54,3

* This product is not a standard stock article. Produced only to customer order. Ask for an individual quotation.



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