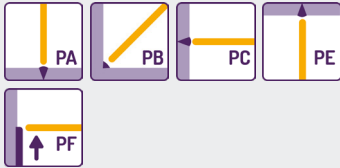


### Processing information

Re-drying: 250 – 300 °C/2 h

Welding positions:



Polarity:



Whether preheating is required depends on the base material.

### Application

Nickel-base electrode for high-quality crack-resistant joint welding and plating on identical nickelchromium and nickel-chromium-ferrous alloys, (heat-resistant) Cr and CrNi (Mo, N) steels and nickel-alloyed cold-tough pressure tank steel. For austenite-ferrite joints (e.g. 1.4583 with 16Mo3) Usable at working temperatures between -196 °C and 800 °C (in case of sulphurous atmosphere only up to 500 °C).

This electrode is very well suited for fixed position welding. The fully austenitic weld metal is chemically stable, cold-tough, heat-resistant, scale-resistant up to 1,000 °C and resistant against embrittlement.

### Field



**Characteristic  
basic-coated**

**Standards  
ISO 14172  
E Ni 6082  
(NiCr 20 Mn 3 Nb)**

**AWS A 5.11  
= E NiCrFe-3**

**Material no.  
2.4648**

### Materials

<b>1.4876</b>	X 10 NiCrAlTi 32-21	- Alloy 600
<b>2.4631</b>	NiCr 20 TiAl	- Alloy 800
<b>2.4669</b>	NiCr 15 Fe 7 TiAl	- Alloy 80A
<b>2.4816</b>	NiCr 15 Fe	- Alloy X750

### All Weld Metal Mechanical Properties

<b>Heat Treatment</b>	AW						
<b>Structure</b>	Austenite						
<b>Weld Metal Composition [%]</b>							
C	Si	Mn	Cr	Mo	Nb	Fe	Ni
0,03	0,4	5	19	1,5	2,2	3	B
<b>Yield Strength Rp 0,2 [MPa]</b>		> 400					
<b>Tensile Strength Rm [MPa]</b>		> 620					
<b>Elongation A5 [%]</b>		> 35					
<b>Charpy Impact Value ISO-V [J/RT]</b>		> 90					

### Welding Current, Packaging

Item no.	Dm./Länge [mm]	Amperage [A]	kg/Pack	≈ Piece/Pack	kg/1000 Pc.
<b>00.765.250</b>	2,50/300	70 - 100	4,0	228	17,0
<b>00.765.323</b>	3,25/350	100 - 130	5,0	153	32,5
<b>00.765.403*</b>	4,00/350	120 - 160	5,0	104	52,6

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



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