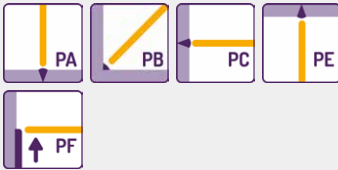


### Processing information

Re-drying: 300 - 350 °C/2 h

Welding positions:



Polarity:



### Application

General purpose electrode applicable for assembly and repair welding of unalloyed and low-alloyed steels in industry and craft. In particular, it provides good welding properties in fixed positions and with AC current.

### Field



**Characteristic**  
**basic-coated**  
**with non-basic**  
**components,**  
**double-coated**

### Standards

**ISO 2560-A**  
**E 38 2 B 32 H10**

**AWS A 5.1**  
**E 7016**

### Approvals



### Materials

Construction steels	S235 - S355
Fine-Grained steels	S275 - S355
Ship steels	A32/36, D32/36, E32/36, A50, D40
Boiler steels	P195 - P355
Pipe steels	L210 - L360
Cast steels	GE200, GE240, GP 240, G20Mn5, G21Mn5
Reinforcing steels	BSt 420, BSt 500

### All Weld Metal Mechanical Properties

Heat Treatment	AW
Weld Metal Composition [%]	
C	0,08
Si	0,7
Mn	0,9
Yield Strength Re [MPa]	> 420
Tensile Strength Rm [MPa]	510-610
Elongation A5 [%]	> 22
Charpy Impact Value ISO-V [J/-20°C]	> 47

### Welding Current, Packaging

Item no.	Dia./Length [mm]	Amperage [A]	kg/Pack	= Piece/Pack	kg/1000 Pc.
00.131.253	2,50/350	80 - 100	4,3	216	19,9
00.131.323	3,25/350	100 - 130	4,3	130	33,1
00.131.404	4,00/450	120 - 160	5,6	89	62,9



.kjellberg.de

Kjellberg Finsterwalde  
Elektroden und  
ZusatzMaterials GmbH  
Ludwig-Erhard-Str. 12  
03238 Finsterwalde  
Germany

Copyright © 2018 | E18-12-17E  
Kjellberg Finsterwalde

+49 3531 50768-0

elektrode@kjellberg.de