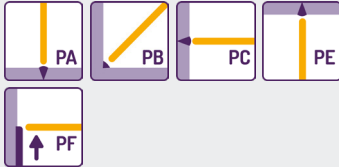


### Processing information

Re-drying: 300 - 350 °C/2 h

Welding positions:



Polarity:



### Application

With a molybdenum content of 0.4 % in the weld metal, the electrode is suitable for steel 16Mo3. By adding a low nickel content this stainless steel electrode is tough at low temperatures up to -30 °C. It is especially suitable for pipe steel.

### Field



**Characteristic  
basic-coated**

**Standards**  
ISO 3580-A  
E Mo Z B 42  
ISO 2560-A  
E 50 4 1 NiMoB 42

**AWS A 5.5  
E 7018-A1**

### Approvals



Materials	
Construction steels	S275 bis S355
Fine-Grained steels	S275 bis S500
Ship steels	A32/36, D32/36, E32/36, F32/36, A/D/E/F40
Boiler steels	P195 bis P500, 16Mo3
Pipe steels	L210 bis L450
Cast steels	GP240, G20Mo5, G21Mn5
Betonstahl	BSt 420, BSt 500

All Weld Metal Mechanical Properties					
Heat Treatment					SR
Weld Metal Composition [%]					
C	Si	Mn	Ni	Mo	
0,08	0,5	1,4	0,6	0,4	
Yield Strength Re [MPa]					> 550
Tensile Strength Rm [MPa]					580-620
Elongation A5 [%]					> 24
Charpy Impact Value ISO-V [J/-20 °C]					> 100

### Welding Current, Packaging

Item no.	Dia./Length [mm]	Amperage [A]	kg/Pack	= Piece/Pack	kg/1000 Pc.
00.550.253*	2,50/350	90 - 110	4,6	215	21,4
00.550.323*	3,25/350	110 - 150	5,0	146	34,2
00.550.404*	4,00/450	140 - 180	6,0	92	65,2
00.550.504*	5,00/450	180 - 220	6,0	60	100,0

\* 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  
Zusatzwerkstoffe GmbH  
Ludwig-Erhard-Str. 12  
03238 Finsterwalde  
Germany

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Kjellberg Finsterwalde

+49 3531 50768-0

elektrode@kjellberg.de