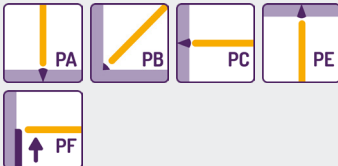


Processing information

Welding positions:



Polarity:



Application

Special electrode for joint welding on structural steels resistant to weathering and Cu/Ni-alloyed fine grained steels in steel and pipe construction, machine building, bridge construction and wagon building.

Field



**Characteristic
basic-coated**

**Standards
ISO 2560-A
E 42 2 Z1NiCu B42**

**AWS A 5.5
E 8018-W**

Materials

**Resistant to
weathering steel**

S 235xW - S 355xW
(WtSt 37, WtSt 52)
1.8946 S355J2WP+N
(COR-TEN® A, PATINAX 355P)
1.8965 S355J2W+N
(COR-TEN® B, PATINAX 355)

Reinforcing steels

BSt 420, BSt 500

All Weld Metal Mechanical Properties

Heat Treatment AW

Weld Metal Composition [%]

C	Si	Mn	Ni	Cu
0,08	0,5	1,0	0,6	0,5

Yield Strength Re [MPa] > 450

Tensile Strength Rm [MPa] 550-640

Elongation A5 [%] > 24

Charpy Impact Value ISO-V [J/-20°C] > 80

Welding Current, Packaging

Item no.	Dia./Length [mm]	Amperage [A]	kg/Pack	= Piece/Pack	kg/1000 Pc.
00.960.253	2,50/350	80 - 110	4,8	217	22,1
00.960.323	3,25/350	110 - 140	5,0	147	34,0



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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