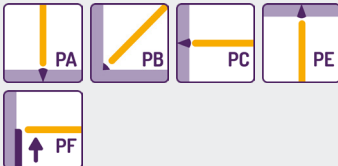


Processing information

Welding positions:



Polarity:



Application

General purpose electrode especially suitable for joint welding in pipeline, container and boiler construction and ship building. Ideal for fixed position welding and root welding as well as for tube seams. The welding result: finely rippled, well-formed and x-ray safe seams without undercutting. Further advantages are fine drop transfer, low spatter and easy slag removal. The weld metal has high mechanical properties – good cold toughness.

Field



Characteristic
rutile-basic-coated

Standards
**ISO 2560-A
E42 2 Z RB 12
AWS A 5.1
E 6013**

Approvals



Materials	
Construction steels	S235 - S355
Fine-Grained steels	S275 - S355
Ship steels	A32/36, D32/36, E 32/36, A40, D40, E40
Boiler steels	P195 - P355
Pipe steels	L210 - L360
Cast steels	GE200, GE240, GP240, G21Mn5
Reinforcing steels	BSt 420, BSt 500

All Weld Metal Mechanical Properties				
Heat Treatment				AW
Weld Metal Composition [%]				
C	Si	Mn	Ni	
0,08	0,25	0,6	0,8	
Yield Strength Re [MPa]				> 440
Tensile Strength Rm [MPa]				540-610
Elongation A5 [%]				> 23
Charpy Impact Value ISO-V [J/-30°C]				> 60

Welding Current, Packaging

Item no.	Dia./Length [mm]	Amperage [A]	kg/Pack	≈ Piece/Pack	kg/1000 Pc.
00.210.253	2,50/350	80 - 110	5,0	244	20,5
00.210.323	3,25/350	110 - 140	5,0	148	33,8



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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