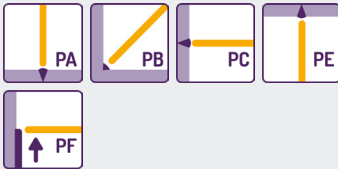


### Processing information

Welding positions:



Polarity:



### Application

General purpose electrode for root and fixed position welding in pipeline, container and boiler construction and ship building. It produces a finely rippled, well-formed and x-ray safe welding seam with notch-free transition to the base material. Another advantage is the easy slag removal - also in root positions.

Field



Characteristic  
**rutile-basic-coated**

Standards  
**ISO 2560-A  
E38 2 RB 12  
AWS A 5.1  
E 6013**

Approvals



Materials	
Construction steels	S235 - S355
Fine-Grained steels	S275 - S355
Ship steels	A, B, D, E, A32/36, D32/36, E 32/36
Boiler steels	P195 - P275
Pipe steels	L210 - L245
Cast steels	GE200, GE240
Reinforcing steels	BSt 420, BSt 500

All Weld Metal Mechanical Properties	
Heat Treatment	AW
Weld Metal Composition [%]	
C	0,08
Si	0,15
Mn	0,5
Yield Strength Re [MPa]	> 400
Tensile Strength Rm [MPa] Elongation	470-530
A5 [%]	> 22
Charpy Impact Value ISO-V [J/-20°C]	> 60

### Welding Current, Packaging

Item no.	Dia./Length [mm]	Amperage [A]	kg/Pack	≈ Piece/Pack	kg/1000 Pc.
00.200.253	2,50/350	80 - 110	4,8	242	19,8
00.200.323	3,25/350	110 - 140	4,8	144	33,3



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