



More information

Kjellberg[®]
FINSTERWALDE

WELDING

Cutting

Engineering

AQUAWELD

FACTS

Applications

- Welding work in fresh, brackish and sea water up to 20 m water depth
- Unalloyed mild steels with carbon equivalent CEV according to IIW of max. 0,4 %

(CEV = C+Mn/6+(Cr+Mo+V)/5+(Ni+Cu)/15 in %)

Advantages

- Good weldability in all positions
- No working in, kneading of the weld metal required
- Low tendency to splatter
- Smooth weld seams

Standards

DIN 2302: E 38 0 Z RB 2 UW 20 fr



AQUAWELD

Certified stick electrode for shielded metal arc welding under water

As a rutile-based coated stick electrode for hyperbaric wet arc welding under water, AQUAWELD meets all the requirements placed on these special welding consumables. Nationally and internationally recognised and widely used, it is used for assembly and repair welding in the offshore industry, in harbour construction, shipbuilding and hydraulic steelwork.

The electrode is characterised by its simple and easy-to-learn handling. Even beginners and inexperienced welding divers achieve excellent results with the AQUAWELD – even under difficult conditions. The specially developed recipe of the coating components ensures a stable arc and compensates for the burn-off of the alloy and accompanying elements. The protective layer ensures optimum protection of both the cladding and the welder.

Technical data

Typical analysis	C	0,05 %
	Si	0,25 %
	Mn	0,5 %
	Mo	0,5 %
Yield strength	Re	≥ 440 MPa
Tensile strength	Rm	≥ 480 MPa
Notched-bar impact value	ISO-V	≥ 30 J / -20 °C

Kjellberg FINSTERWALDE ®, ©, Kjellberg and InFocus are trademarks of Kjellberg Foundation registered in the European Union and possibly other countries.

www.kjellberg.de

Kjellberg Finsterwalde
Elektroden und Zusatzwerkstoffe GmbH
Ludwig-Erhard-Straße 12
03238 Massen | Germany

Copyright © 2023 Kjellberg Finsterwalde
1310712023

+49 3531 50768-0

✉ electrode@kjellberg.de