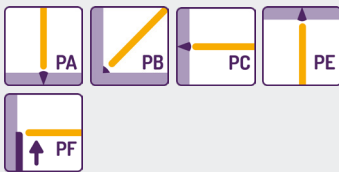


Processing information

Preheating and interpass temperature 250 up to 350 °C depending on base material, shape of material and thickness.

Re-drying: 300 - 350 °C/2 h

Welding positions:



Polarity:



Tempering: min. 0.5 h at 700 °C
down-cooling at resting air

Annealing: 0.5 h at 950 °C down-cooling by air, afterwards 0.5 h at 700 °C down-cooling by air

Application

Electrode for joint welding on boiler and pipe steel as well as similar chromiummolybdenum-alloyed, pressure-hydrogen-resistant steel. It is preferred for longterm use on the creep-resistant steel 10CrMo9-10 at working temperatures of up to 600 °C. Further, it is suitable for joint welding and surfacing on similar-alloyed case-hardened and heat-treated steel.

Field



Characteristic basic-coated

Standards
ISO 3580-A
E CrMo 2 B 42
AWS A 5.5
E 9018-B3

Approvals



Materials			
1.7259	26 CrMo 7	1.7380	10 CrMo 9-10
1.7273	24 CrMo 10	1.7382	619 CrMo 9-10
1.7276	10 CrMo 11	1.7383	11 CrMo 9-10
1.7281	16 CrMo 9-3	1.7387	612 CrMo 9-10
1.7379	617 CrMo 9-10	1.8075	10 CrSiMoV 7
	ASTM	A 335 (P22)	

All Weld Metal Mechanical Properties					
Heat Treatment					A
Weld Metal Composition [%]					
C	Si	Mn	Cr	Mo	
0,08	0,4	0,9	2,2	1,1	
Yield Strength Re [MPa]					> 400
Tensile Strength Rm [MPa]					500 - 600
Elongation A5 [%]					> 20
Charpy Impact Value ISO-V [J/+20 °C]					> 47

Welding Current, Packaging

Item no.	Dia./Length [mm]	Amperage [A]	kg/Pack	= Piece/Pack	kg/1000 Pc.
00.491.253	2,50/350	80 - 110	4,3	195	22,1
00.491.323	3,25/350	110 - 150	4,8	143	33,6
00.491.403*	4,00/350	140 - 180	4,8	95	50,5

* This product is not a standard stock article. Produced only to customer order. Ask for an individual quotation.

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