

### Processing information

Re-drying: 250 – 300 °C/2 h

Welding positions:



Polarity:



Whether preheating is required depends on the base material, for surfacing at crack-sensitive materials up to 400 °C.

### Application

Electrode for highly heat-resistant, corrosion-resistant surfacings with good thermal shock resistance abilities. It is especially suitable for repairs and fabrication of hot working tools, for example forging dies, die blocks, press jacks, piercers, trimming cutters etc. This stick electrode is also ideal for surfacings on unalloyed and low-alloyed high-tensile steel. The weld metal is corrosion-resistant under oxidising and reducing conditions, especially tough and crack-resistant, creep-resistant and hardenable at approx. 780 °C. It is workhardenable under shock load and mechanically workable.

### All Weld Metal Mechanical Properties

#### Weld Metal Composition [%]

C	Cr	Mo	W	Fe	Co	Ni
0,06	16	17	4,5	5	2,5	B

#### Hardness [HB]

Yield Strength Rp 0,2 [MPa]	> 390
Tensile Strength Rm [MPa]	> 680
Elongation A5 [%]	40
As-welded	≈ 220
Workhardened	≈ 400

### Welding Current, Packaging

Item no.	Dm./Länge [mm]	Amperage [A]	kg/Pack	≈ Piece/Pack	kg/1000 Pc.
00.617.253*	2,50/350	70 – 100	5,0	145	34,5
00.617.323*	3,25/350	120 – 140	5,0	88	56,8
00.617.403*	4,00/350	160 – 190	5,0	57	87,7

\* This product is not a standard stock article. All dimensions are produced only to customer order. Ask for an individual quotation.

### Field



**Characteristic**  
**rutile-coated,**  
**180 % recovery**

**Standards**  
**DIN EN 14700**  
**E Z Ni 2**  
**DIN 8555**  
**E 23-UM-250 CNKPTZ**

**ISO 14172**  
**NI 6275/**  
**Ni Cr 15 Mo 16 Fe 5 W 3**

**AWS A 5.1**  
**E Ni Cr Mo-5**

**Material no.**  
**≈ 2.4887**



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