

Processing information

Re-drying: 300 – 350 °C/2 h

Welding positions:



Polarity:



Whether preheating is required depends on the base material, crack-sensitive materials up to min. 350 °C.

Application

Electrode for very hard and tough surfacings on heavily wear-loaded machine parts from unalloyed and low-alloyed metals. It is especially suitable for repairs and manufacture of cold cutting tools with high edge-holding properties, for example die plates and cutting bars. The surfacing is only machinable by grinding.

Field



**Characteristic
basic-coated**

**Standards
DIN EN 14700
E Z Fe2
DIN 8555
E 2-UM-55**

All Weld Metal Mechanical Properties

Weld Metal Composition [%]

C	Si	Mn	Cr	Ni	Mo
0,25	0,65	1	2,5	1	0,4

Hardness [HRC]

As-welded	52 – 57
-----------	---------

Welding Current, Packaging

Item no.	Dm./Länge [mm]	Amperage [A]	kg/Pack	= Piece/Pack	kg/1000 Pc.
00.641.324	3,25/450	120 – 160	6,0	130	46,2
00.641.404	4,00/450	150 – 190	6,0	85	70,6
00.641.504	5,00/450	180 – 240	6,0	56	107,1



 .kjellberg.de

Kjellberg Finsterwalde
Elektroden und
ZusatzMaterials GmbH
Ludwig-Erhard-Str. 12
03238 Finsterwalde
Germany

Copyright © 2018 | E18-12-61E
Kjellberg Finsterwalde

 +49 3531 50768-0

 elektrode@kjellberg.de