

Processing information

Re-drying: 300 – 350 °C/2 h

Welding positions:



Polarity:



Soft Annealing:

780 – 820 °C, 3 – 5 h, Furnace cooling

Hardening:

1.000 – 1.050 °C, Quenching in oil

When surfacing crack-sensitive materials preheating at min. 350 °C necessary, eventually buffering (single layer) with FINOX 4370 AC.

Application

Electrode for tough-hard, impact-resistant and abrasion-resistant surfacings on unalloyed and low-alloyed metals of higher toughness. It is especially suitable for surfacings on machine parts, digging teeth, blow bars, scrapers, conveyor screws, mill hammers, mixer arms, crushing jaws and cones. The weld metal is workable by grinding only and can be soft-annealed and hardened.

Field



Characteristic
basic-coated

Standards
DIN EN 14700
E Z Fe6
DIN 8555
E 6-UM-60 P

All Weld Metal Mechanical Properties

Weld Metal Composition [%]

C	Si	Mn	Cr	Mo	V
0,5	1	0,5	9	1	1,5

Hardness [HRC]

As-welded	58 – 62
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Welding Current, Packaging

Item no.	Dm./Länge [mm]	Amperage [A]	kg/Pack	≈ Piece/Pack	kg/1000 Pc.
00.613.253	2,50/350	80 – 110	5,0	229	21,8
00.613.324	3,25/450	110 – 140	6,0	127	47,2
00.613.404	4,00/450	140 – 180	6,0	84	71,4
00.613.504	5,00/450	170 – 220	6,0	54	111,1



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