

Processing information

Re-drying: 300 – 350 °C/2 h
(if required)

Welding positions:



Polarity:



High-manganese steels should be cold-welded, if possible. Larger components need to be cooled. Interpass temperature is max. 250 °C. Massive components from unalloyed, crack-sensitive steels with higher carbon content need to be pre-heated to 250–350 °C.

Application

The austenitic hard-manganese steel electrode is suitable for wear-resistant surfacings on materials and machine parts from hard-manganese steel, for example digging teeth, blow bars, crushing jaws, rail frogs and crossing pieces which are mainly impact and shock-loaded. The weld metal has in welding condition a hardness of 200 HB which can be increased up to 500 HB by work-hardening under mechanical strain.

Field



**Characteristic
rutile-coated**

**Standards
DIN EN 14700
E Fe9
DIN 8555
E 7-UM-200-500 KP**

All Weld Metal Mechanical Properties

Weld Metal Composition [%]

C	Si	Mn	Cr
0,8	0,5	16	14

Hardness [HB]

As-welded	≈ 180
workhardened	≈ 500

Welding Current, Packaging

Item no.	Dm./Länge [mm]	Amperage [A]	kg/Pack	≈ Piece/Pack	kg/1000 Pc.
00.626.323	3,25/350	110 - 150	5,0	94	53,2
00.626.404	4,00/450	140 - 180	6,0	57	105,3
00.626.504	5,00/450	180 - 220	6,0	40	150,0



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