Kjellberg® FINSTERWALDE

FINOX 4459 AC

Processing informatione

Re-drying: 300 – 350 °C/2 h

Welding positions:

Polarity:

Wheter preheating is required depends on the base material. For low dilution low heat input necessary. Interpass temperature max. 200 °C. Otherwise welding without preheating

Application

Electrode for joint welding of unalloyed and low-alloyed steel with each other and among each other and with high-alloyed chromium, chromium-nickel, and chromium-nickel-molybdenum steel and cast steel, for austenite-ferrite joints at working temperatures of up to 300 °C. This stainless steel electrode is also suitable for welding of buffering layers and intermediate layers for chemically stable claddings. The weld metal is already corrosion-resistant on the first layer and furthermore, it is especially crack-resistant, also regarding steel which is difficult to weld. At working temperatures of more than 500 °C there is the danger of embrittlement.

All Weld Metal Mechanical Properties						
Heat Treatment						AW
Structure						Austenite with approx. 15% Ferrite
Weld Metal Composition [%]						
C	Si	Mn	Cr	Ni	Mo	
0,02	0,9	0,7	23	13	2,6	
Yield Strength Rp 0,2 [MPa]						> 450
Tensile Strength Rm [MPa]						> 600
Elongation A5 [%]						> 30
Charpy Impact Value ISO-V [J/RT]						> 50

Welding Current, Packaging

Item no.	Dm./Länge [mm]	Amperage [A]	kg/Pack	= Piece/Pack	kg/1000 Pc.
00.724.250	2,50/300	80 - 100	4,0	216	18,5
00.724.323	3,25/350	100 - 130	5,0	136	36,8
00.724.403	4,00/350	120 - 160	5,0	90	55,6

Field

Characteristic

rutile-coated, core wire-alloyed

Standards

ISO 3581-A
E 23 12 2 L R 32

AWS A 5.4
E 309 L Mo-16

Material no.

1.4459

Approvals

DNV·GL

THE ORIGINAL MADE IN GERMANY SINCE 1921

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