Kjellberg® FINSTERWALDE

STICK ELECTRODES, STAINLESS-RESISTANT

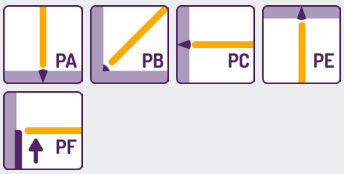
FINOX 4551 B

Processing informatione

Wheter preheating is required depends on the base material, otherwise not necessary. Interpass temperature max. 150 °C.

Re-drying: 250 - 300 °C/2 h (if required)

Welding positions:



Polarity:

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Application

Electrode for joint welding on unstabilised and stabilised austenitic, chemically stable chromium-nickel steel at working temperatures of up to 400 °C as well as for corrosion-resistant chromium steel and claddings of similar alloys.

Field

Characteristic

basic-coated, core wire-alloyed

Standards

ISO 3581-A
E 19 9 Nb B 22

AWS A 5.4
E 347-15

Material no.

1.4551

Materials			
1.4301	X 5 CrNi 18-10	**1.4550**	X 6 CrNiNb 18-10
1.4306	X 2 CrNi 19-11	**1.4552**	GX 5 CrNiNb 19-11
1.4311	X 2 CrNiN 18-10	-	AISI 304 AISI 304L AISI 304LN AISI 321 AISI 347
1.4541	X 6 CrNiTi 18-10		

All Weld Metal Mechanical Properties						
Heat Treatment						AW
Structure						Austenite with approx. 8 % ferrite
Weld Metal Composition [%]						
C	Si	Mn	Cr	Ni	Nb	
0,04	0,5	1,2	19,5	10	0,5	
Yield Strength Rp 0,2 [MPa]						> 350
Tensile Strength Rm [MPa]						> 550
Elongation A5 [%]						> 25
Charpy Impact Value ISO-V [J/RT]						> 75

Welding Current, Packaging

Item no.	Dm./Länge [mm]	Amperage [A]	kg/Pack	≈ Piece/Pack	kg/1000 Pc.
00.705.250*	2,50/300	70 - 100	4,0	266	15,0
00.705.323*	3,25/350	100 - 130	5,0	170	29,5

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

THE ORIGINAL MADE IN GERMANY SINCE 1921

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