

Processing information

Re-drying: 250 – 300 °C/2 h

Welding positions:



Polarity:



Whether preheating is required depends on the base material.

Application

Nickel-base electrode for joint welding and plating on the same nickel-chromiummolybdenum and similar nickel-chromium steels, (heat-resistant) Cr and CrNi (Mo, N) steels and nickel-alloyed cold-tough pressure tank steels. Usable at working temperatures between -196 °C and 1,000 °C (In case of sulphurous atmosphere only up to 500 °C).

The fully austenitic weld metal is chemically stable, cold-tough, heat-resistant, scaleresistant up to 1,000 °C and resistant against embrittlement. High resistance against corrosive media.

Field



**Characteristic
rutile-coated**

Standards

**ISO 14172
E Ni 6625
(NiCr 22 Mo 9 Nb)**

**AWS A 5.11
E NiCrMo-3**

Material no.

2.4621

Materials

1.4529	X 1 NiCrMoCuN 25-20-7	- Alloy 600
1.4876	X 10 NiCrAlTi 32-21	- Alloy 625
2.4816	NiCr 15 Fe	- Alloy 800
2.4856	NiCr 22 Mo 9 Nb	- Alloy 825
2.4858	NiCr 21 Mo	

All Weld Metal Mechanical Properties

Heat Treatment	AW					
Structure	Austenite					
Weld Metal Composition [%]						
C	Si	Mn	Cr	Mo	Nb	Ni
0,04	0,25	0,2	22	9	3,5	B
Yield Strength Rp 0,2 [MPa]		> 420				
Tensile Strength Rm [MPa]		> 760				
Elongation A5 [%]		> 30				
Charpy Impact Value ISO-V [J/RT]		> 90				
[J/-196 °C]		> 40				

Welding Current, Packaging

Item no.	Dm./Länge [mm]	Amperage [A]	kg/Pack	≈ Piece/Pack	kg/1000 Pc.
00.761.253	2,50/350	90 - 120	5,0	148	33,8
00.761.323	3,25/350	120 - 160	5,0	85	58,8
00.761.403	4,00/350	150 - 190	5,0	56	89,3



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

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Kjellberg Finsterwalde

+49 3531 50768-0

elektrode@kjellberg.de