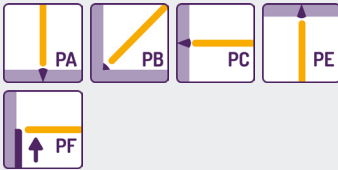


### Processing information

Re-drying: 300 - 350 °C/2 h

Welding positions:



Polarity:



### Application ■■■

General purpose electrode with good mechanical properties which is suitable for welding of unalloyed and low-alloyed steel in industry and craft. It is characterised by good welding properties in fixed positions and with AC current.

### Field



**Characteristic**  
**basic-coated**  
**with non-basic**  
**components**

**Standards**  
**ISO 2560-A**  
**E 42 3 B 12 H10**

**AWS A 5.1**  
**E 7016**

### Approvals



### Materials

Construction steels	S235 - S355
Fine-Grained steels	S275 - S420
Ship steels	A32/36, D32/36, E32/36, A40, D40
Boiler steels	P195 - P355
Pipe steels	L210 - L360
Cast steels	GE200, GE240, GP240, G21Mn5
Reinforcing steels	BSt 420, BSt 500

### All Weld Metal Mechanical Properties

Heat Treatment	AW	
Weld Metal Composition [%]		
C	Si	Mn
0,08	0,4	1,0
Yield Strength Re [MPa]	> 450	
Tensile Strength Rm [MPa]	510-610	
Elongation A5 [%]	> 24	
Charpy Impact Value ISO-V [J/-30°C]	> 100	

### Welding Current, Packaging

Item no.	Dia./Length [mm]	Amperage [A]	kg/Pack	≈ Piece/Pack	kg/1000 Pc.
00.130.253	2,50/350	80 - 100	4,3	205	21,0
00.130.323	3,25/350	100 - 130	4,3	126	34,1
00.130.404	4,00/450	120 - 160	5,3	76	69,7
00.130.504	5,00/450	160 - 200	5,3	50	106,0



[kjellberg.de](http://www.kjellberg.de)

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

Copyright © 2018 | E18-12-18E  
Kjellberg Finsterwalde

+49 3531 50768-0

✉ [elektrode@kjellberg.de](mailto:elektrode@kjellberg.de)