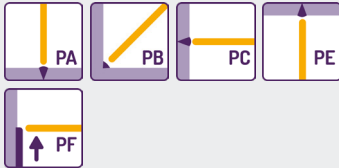


### Processing information

Re-drying: 300 - 350 °C/2 h

Welding positions:



Polarity:



### Application

With a molybdenum content of 0.4 % in the weld metal, this electrode is especially suitable for steel 16Mo3. Typical application areas are boiler, container and pipeline construction and at working temperatures of up to 520 °C.

### Field



**Characteristic  
basic-coated**

### Standards

**ISO 3580-A  
E Mo B 42**

**AWS A 5.5  
E 7018-A1**

### Approvals



### Materials

Construction steels	S275 bis S355
Fine-Grained steels	S275 bis S460
Boiler steels	P195 bis P460, 16Mo3
Pipe steels	L210 bis L450
Cast steels	GP 240, G20Mo5

### All Weld Metal Mechanical Properties

Heat Treatment	SR		
Weld Metal Composition [%]			
C	Si	Mn	Mo
0,08	0,4	1,0	0,4
Yield Strength Re [MPa]	> 450		
Tensile Strength Rm [MPa]	540-590		
Elongation A5 [%]	> 24		
Charpy Impact Value ISO-V [J/-10 °C]	> 80		

### Welding Current, Packaging

Item no.	Dia./Length [mm]	Amperage [A]	kg/Pack	= Piece/Pack	kg/1000 Pc.
00.470.253	2,50/350	70 - 100	4,3	192	22,4
00.470.323	3,25/350	110 - 150	4,8	139	34,5
00.470.403	4,00/350	140 - 180	4,7	90	52,2



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