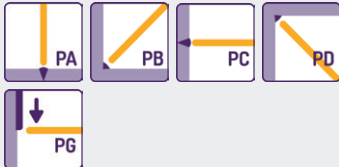


Processing information

Welding positions:



Polarity:



High-quality welds require appropriate weld preparation, well-trained personnel, and compliance with recognised standards of good practice.

Application

Rutile-basic coated special-purpose electrode with a conducting and waterrepellent coating for manual wet underwater welding. Suitable for assembly and repair welding in up to 20 m water depth for offshore and harbour construction, shipbuilding, and steel hydraulic engineering.

The covered electrode has been tested by GSI and approved as a welding filler material to DVS 1801 up to a water depth of 10 metres.

Materials

Mild steels with a carbon equivalent value CEV (IIW) of 0.4% maximum (CEV = C+Mn/6+(Cr+Mo+V)/5+(Ni+Cu)/15 in %).

The welding electrode is not suitable for welding of higher-strength steels. These materials can be subject to cracking from underwater welding.

All Weld Metal Mechanical Properties

Heat Treatment AW

Weld Metal Composition [%]

C	Si	Mn	Mo
0,05	0,25	0,5	0,5

Yield strength Re [MPa] ≥ 380

Tensile Strength Rm [MPa] ≥ 470

Charpy Impact Value ISO -V [J/θ °C] ≥ 27

Welding Current, Packaging

Item no.	Dm./Länge [mm]	Amperage [A]	kg/Pack	≈ Piece/Pack	kg/1000 Pc.
00.995.323	3,25/350	140 - 190	4,3	115	374

Field



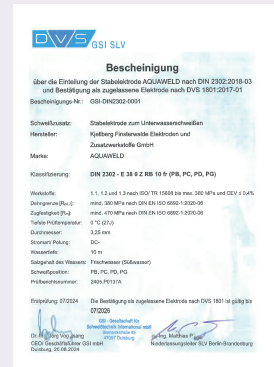
use

Underwater Electrodes for Welding

Characteristic rutile-basic-coated

Standards DIN 2302 E 38 0 Z RB 10 fr

Approvals



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

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