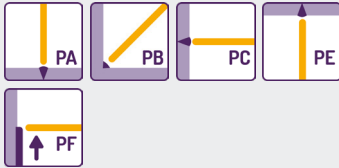


### Processing information

Re-drying: 300 - 350 °C/2 h

Welding positions:



Polarity:



Whether preheating is required depends on the base material, for low dilution low heat input required. Otherwise preheating not necessary. Interpass temperature max. 200 °C.

### Application

Electrode for joint welding and surfacing on steel and cast steel of the same or similar alloy, for joint welding on high-tensile unalloyed and low-alloyed construction steel, heat-treated steel, tool steel and high-manganese steel as well as for joint welding of dissimilar steel with high-alloyed, stainless steel. Furthermore, this rod electrode is ideal for crack-resistant and tough-hard intermediate layers when hard-surfacing as well as for wear-resistant, workhardened and warm-hardened surfacing. The austenitic-ferritic weld metal is stainless, corrosion-resistant and suitable for working temperatures of up to 300 °C. Due to the enhanced delta-ferrite content of the weld metal black-and-white joints are very resistant against hot-cracking.

### Field



### Characteristic

**rutile-coated,  
core wire-alloyed**

### Standards

**ISO 3581-A  
E 29 9 R 12  
AWS A 5.4  
E 312-16**

### Material no.

**1.4337**

### Approvals



### All Weld Metal Mechanical Properties

**Heat Treatment** AW

**Structure** Austenite/Ferrite

### Weld Metal Composition [%]

C	Si	Mn	Cr	Ni
0,1	0,9	1	29	9

**Yield Strength Rp 0,2 [MPa]** > 500

**Tensile Strength Rm [MPa]** > 700

**Elongation A5 [%]** > 20

### Welding Current, Packaging

Item no.	Dm./Länge [mm]	Amperage [A]	kg/Pack	≈ Piece/Pack	kg/1000 Pc.
00.723.200	2,00/300	50 - 70	4,0	343	11,7
00.723.250	2,50/300	70 - 100	4,0	226	17,7
00.723.323	3,25/350	100 - 140	5,0	142	35,2
00.723.403	4,00/350	130 - 170	5,0	94	53,2



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