



More information

Kjellberg[®]
FINSTERWALDE

Cutting

Engineering

WELDING

AQUAWELD

FACTS

Applications

- Welding work in fresh, brackish and sea water
- Suitable for use in water up to 20 meters deep
- Unalloyed mild steels with carbon equivalent CEV according to IIW of max. 0,4 %
(CEV = C+Mn/6+(Cr+Mo+V)/5+(Ni+Cu)/15 in %)

Advantages

- Tested and approved quality
- Good weldability in all positions
- No working in, kneading of the weld metal required
- Low tendency to splatter
- Smooth weld seams

Standards

DIN 2302: E 38 0 Z RB 10 fr



AQUAWELD

Stick electrode for shielded metal arc welding under water



As a rutile-based coated stick electrode for hyperbaric wet arc welding under water, AQUAWELD meets all the requirements placed on these special welding consumables. Nationally and internationally recognised and widely used, it is used for assembly and repair welding in the offshore industry, in harbour construction, shipbuilding and hydraulic steelwork.

The electrode is characterised by its simple and easy-to-learn handling. Even beginners and inexperienced welding divers achieve excellent results with the AQUAWELD – even under difficult conditions. The specially developed recipe of the coating components ensures a stable arc and compensates for the burn-off of the alloy and accompanying elements. The protective layer ensures optimum protection of both the cladding and the welder.

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.

Technical data

Typical analysis	C	0,05 %
	Si	0,25 %
	Mn	0,5 %
	Mo	0,5 %
Yield strength	R _{P0,2}	≥ 380 MPa
Tensile strength	R _m	≥ 470 MPa
Notched-bar impact value	ISO-V	≥ 27 J / 0 °C

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