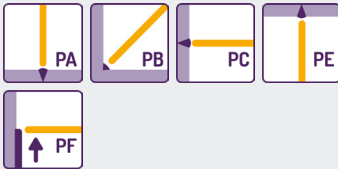


### Processing information

Welding positions:



Polarity:



### Application

Electrode for welding unalloyed and low-alloyed steel. It is especially suitable for welding thin sheets and thin-walled pipes and profiles. The electrode is characterised by fine drop transfer, low spatter, very finely rippled seam surfaces without undercutting and easy slag removal. Ignition, re-ignition and welding is also possible with low current. The arc is smooth and stable.

### Field



Characteristic  
**rutile-basic-coated**

Standards  
**ISO 2560-A  
E42 0 RB 12  
AWS A 5.1  
E 6013**

### Approvals



| Materials           |                             |
|---------------------|-----------------------------|
| Construction steels | S235 - S355                 |
| Fine-Grained steels | S275 - S355                 |
| Ship steels         | A, B, D, A32/36, D32/36     |
| 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                                    | 0,1     |
| Si                                   | 0,25    |
| Mn                                   | 0,5     |
| Yield Strength Re [MPa]              | > 440   |
| Tensile Strength Rm [MPa]            | 510-560 |
| Elongation A5 [%]                    | > 22    |
| Charpy Impact Value ISO-V [J/0°C]    | > 60    |

### Welding Current, Packaging

| Item no.   | Dia./Length [mm] | Amperage [A] | kg/Pack | = Piece/Pack | kg/1000 Pc. |
|------------|------------------|--------------|---------|--------------|-------------|
| 00.400.202 | 2,00/350         | 60 - 80      | 1,6     | 170          | 10,0        |
| 00.400.253 | 2,50/350         | 80 - 100     | 4,6     | 226          | 20,4        |
| 00.400.323 | 3,25/350         | 110 - 140    | 4,6     | 131          | 35,1        |
| 00.400.403 | 4,00/350         | 130 - 170    | 4,6     | 90           | 51,1        |



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