

Processing information

Re-drying: 300 – 350 °C/2 h
(if required)

Welding positions:



Polarity:



Soft Annealing:
850 °C, 2 – 5 h Furnace cooling

Hardening: 1220 °C, Quenching in oil
or compressed air

Tempering:
530 °C, 2 h, Air cooling

Whether preheating is required depends
on the base material, crack-sensitive
materials up to min. 350 °C.

Application

Electrode for hard, wear-resistant surfacings
with high toughness. It is used for armoring of
cutting edges on tools from low-alloyed steel and
for repairs on high-speed tools. The weld metal is
very resistant against abrasion, impact and shock-
resistant and has good edge-holding properties.

All Weld Metal Mechanical Properties

Weld Metal Composition [%]

C	Si	Mn	Cr	Mo	W	V
0,9	0,3	0,5	4,5	8	2	1,5

Hardness [HRC]

As-welded	59 – 62
After tempering	63 – 65
Oil hardening	60 – 63

Field



**Characteristic
rutile-coated**

**Standards
DIN EN 14700
E Fe4
DIN 8555
E 4-UM-60 ST**

Welding Current, Packaging

Item no.	Dm./Länge [mm]	Amperage [A]	kg/Pack	= Piece/Pack	kg/1000 Pc.
00.612.253	2,50/350	80 - 110	5,0	170	29,4
00.612.323	3,25/350	110 - 140	5,0	101	49,5
00.612.403	4,00/350	130 - 170	5,0	66	75,8



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