

# EZ - 50 B

## CLASSIFICATION

EN ISO 2560-A	AWS / ASME SFA-5.1
E 42 4 B 42 H5	E7018-1

## DESCRIPTION AND APPLICATION

A heavily coated basic electrode for welding of mild and low alloy steels with tensile strength up to 640 N/mm<sup>2</sup>. Also, it is suitable for welding of fine grained steels with yield strength up to 440 N/mm<sup>2</sup>. Hydrogen content of all-weld metal < 5 ml/100 g. Effective efficiency approx. 120%.

Steel grade	HRN	DIN (W. Nr.)	EN / ISO
Constructional steels	Č 0261 to Č 0563	St 33 (1.0035) to St 52-3N (1.0570) StE 420 S (1.0428)	S 185 to S 355 J2G3 Fe 310-0 to Fe 510 D1
Boiler steels	Č 1202 Č 1204 Č 3133 Č 3105	HI (1.0345) HII (1.0425) 17Mn4 (1.0481) 19Mn6 (1.0473)	P235GH P265GH P295GH P355GH
Tube and pipe steels	Č 1212 to Č 3100	St 35.4 (1.0309) to St 52.4 (1.0581) StE 210.7 (1.0307) to StE 360.7 (1.0582)	DX55D to P355T2 L210 to L360NB
Shipbuilding steels	A, B, D, E AH 32 to EH 36	A, B, D, E AH 32 to EH 36	
Fine grained steels	ČRO 250 to ČRO 350 ČPRV 250 to ČPRV 350	StE 285 (1.0486) StE (1.0562) WStE 285 (1.0487) WStE 355 (1.0565)	P275N P355N P275NH P355NH
Cast steels	ČL 0300 to ČL 0500	GS-38 (1.0416) to GS-52 (1.0551)	C18D to S355JRC

## MECHANICAL PROPERTIES OF THE ALL-WELD METAL

R <sub>eL</sub> N/mm <sup>2</sup>	R <sub>m</sub> N/mm <sup>2</sup>	A <sub>5</sub> %	KV (-20°C) J	KV (-40°C) J
> 440	500 - 640	> 26	≥ 120	≥ 47

## APPROXIMATE CHEMICAL COMPOSITION OF THE ALL-WELD METAL

	C	Mn	Si
%	0,08	1,0	0,5

## RECOMMENDED WELDING CURRENT

Ø mm	2,5	3,2	4,0	5,0	6,0
A	60 - 90	110 - 140	140 - 190	170 - 250	240 - 330

## PACKAGING

Electrode dimensions mm	Quantity per ton approx. pieces	Weight of packaging kg
Ø 2,0 x 300	57 000	0,8; 3,2
Ø 2,5 x 300	53 100	0,8; 3,2
Ø 3,2 x 350	26 900	0,8; 3,9
Ø 4,0 x 450	14 400	5,2
Ø 5,0 x 450	9 600	5,4
Ø 6,0 x 450	6 900	5,5

## APPROVALS

ABS (3H10,3Y); BV (3,3YHH); CRS (3YHH); DB; DNV (3YH10); GL (3YH10); LR (3,3YH15); RINA (3YH10); RS (3YHH); TÜV



Marking: **EZ - 50 B**  
Dry before use 2h/300°C