

# EZ - 60 B

## CLASSIFICATION

EN ISO 2560-A	AWS / ASME SFA-5.5
E 50 6 1Ni B 42 H5	E8018-G

## DESCRIPTION AND APPLICATION

A basic coated, alloyed with nickel (Ni), electrode for welding low-alloyed steels with tensile strength from 510 to 670 N/mm<sup>2</sup>. Also suitable for welding fine-grained steels with yield strength up to 460 N/mm<sup>2</sup>, where is required very good impact properties at low temperatures. Hydrogen content of all-weld metal < 5 ml/100 g.

Steel grade	HRN	DIN (W. Nr.)		EN / ISO
Constructional steels	Č 0561 to Č 0745	St 52-3N (1.0570) to St 70-2 (1.0070)		S 355J2G3 to E 360 Fe 510 D1 to Fe 690-2
Boiler steels	Č 3133 Č 3105	17 Mn4 (1.0481)	19Mn6 (1.0473)	P295GH P355GH
Fine-grained steels	ČRO 350 to ČRO 460	StE 355 (1.0562) to StE 460 (1.8905)		P355N P460N
	ČRV 350 to ČRV 460	WSiE 355 (1.0565) WSiE 460 (1.8935)		P355NH P460NH
	ČRM 350 to ČRN 460	TSiE 355 (1.0566) TSiE 460 (1.8915)		P355NL1 P460NL1
Nickel steels		11MnNi53 (1.6212)	13MnNi63 (1.6217)	11MnNi5-3 13MnNi6-3
Cast steels	ČL 0500 ČL 0600	GS-52 (1.0551)	GS-60 (1.0553)	S355JRC S355JO

## 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 (-40°C) J	KV (-60°C) J
> 500	590 - 650	> 22	≥ 80	≥ 47

## APPROXIMATE CHEMICAL COMPOSITION OF THE ALL-WELD METAL

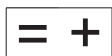
	C	Mn	Si	Ni
%	0,08	1,0	0,5	1,1

## RECOMMENDED WELDING CURRENT

Ø mm	2,5	3,2	4,0	5,0	6,0
A	65 - 80	120 - 140	140 - 180	220 - 250	260 - 300

## PACKAGING

Electrode dimensions mm	Quantity per ton approx. pieces	Weight of packaging kg
Ø 2,5 x 300	53 100	3,2
Ø 3,2 x 350	26 900	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



Marking: **E 8018-G**  
Dry before use 2h/300°C