

EZ - 80 B

CLASSIFICATION

EN ISO 3580-A	AWS / ASME SFA-5.5
E Cr Mo2 B 42	E9018-B3

DESCRIPTION AND APPLICATION

Basic coated electrode alloyed with Cr and Mo. Suitable for welding creep resisting steels whose operating temperature is up to 600°C. It is also suitable for welding of heat treatable steels of similar chemical composition.

Steel grade	HRN	DIN (W. Nr.)	EN / ISO
Creep resisting and heat treatable steels and cast	Č 7401	10CrMo 9 10 (1.7380)	10 CrMo 9-10
		10CrSiMoV (1.8075)	11CrMo 9-10
	Č 4734	30CrMoV 9 (1.7707)	30CrMoV9
		GS-12 CrMo 9 10 (1.7380)	G12CrMo9-10

MECHANICAL PROPERTIES OF THE ALL-WELD METAL

Stress relieved at 760°C.

R _{eL} N/mm ²	R _m N/mm ²	A ₅ %	KV (20°C) J
> 520	620 - 720	> 20	≥ 80

APPROXIMATE CHEMICAL COMPOSITION OF THE ALL-WELD METAL

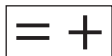
	C	Mn	Si	Cr	Mo
%	0,08	0,8	0,5	2,4	1,0

RECOMMENDED WELDING CURRENT

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

PACKAGING

Electrode dimensions mm	Quantity per ton apprx. 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



Marking: **E 9018-B3**
Dry before use 2h/300°C