

# EZ - KROM 20

## CLASSIFICATION

EN ISO 3581-A	AWS / ASME SFA-5.4
E 18 8 Mn B 22	~ E307-15

## DESCRIPTION AND APPLICATION

A basic coated electrode for welding Cr-Ni stainless steels, steels with poor weldability, and steels with dissimilar structural phases (unalloyed and low-alloy steels as well as manganese steel). Electrode is also suitable for obtaining elastic buffer layer in hardfacing. Weld metal is austenitic Cr-Ni-Mn type, nonmagnetic, wear resistant, and corrosion resistant up to 800°C.

## MECHANICAL PROPERTIES OF THE ALL-WELD METAL

R <sub>p0.2</sub> N/mm <sup>2</sup>	R <sub>m</sub> N/mm <sup>2</sup>	A <sub>5</sub> %	KV (20°C) J
> 350	590 - 690	> 35	> 80

## APPROXIMATE CHEMICAL PROPERTIES OF THE ALL-WELD METAL

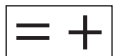
	C	Mn	Si	Cr	Ni
%	0,12	6,0	1,0	18,5	8,0

## RECOMMENDED WELDING CURRENT

Ø mm	2,5	3,2	4,0	5,0
A	65 - 85	90 - 110	125 - 145	150 - 170

## PACKAGING

Electrode dimensions mm	Quantity per ton approx. pieces	Weight of packaging kg
Ø 2,5 x 300	65 000	1,3
Ø 3,2 x 350	33 000	1,2
Ø 4,0 x 350	22 000	1,2
Ø 5,0 x 450	11 300	5,2



Marking: **E 307-15**  
Dry before use 2h/300°C