

EZ - 55 B Mo

CLASSIFICATION

EN ISO 3580-A	AWS / ASME SFA-5.5
E Mo B 42	E7018-A1

DESCRIPTION AND APPLICATION

An Mo-alloyed basic coated electrode for welding of creep resisting steels, persistent on working temperatures up to 550°C.

Steel grade	HRN	DIN (W. Nr.)	EN / ISO	
Constructional steels	Č 0361 to Č 0545	St 37-2 (1.0037) to St 50-2 (1.0050)	S 235JR to E 295 Fe 360B to Fe 490-2	
Fine-grained steels	ČRV 350 to ČRV 420	WStE 355 (1.0565) to WStE 420 (1.8932)	P355NH to P420NH	
Boiler steels	Č 1202	Č 1204	HI (1.0481) HII (1.0473)	P235GH P265GH
	Č 3133	Č 3105	17Mn4 (1.0481) 19Mn6 (1.0473)	P295GH P355GH
	Č 7100		15Mo3 (1.5415)	16M03
Tube and pipe steels	Č 1214	Č 1215	St 35.8 (1.0305) St 45.8 (1.0405)	P235G1TH P255G1TH
Cast steels	ČL 7130	G-22 Mo4 (1.5419)		G20Mo5

MECHANICAL PROPERTIES OF THE ALL-WELD METAL

Stress relieved at 620°C.

R _{eL} N/mm ²	R _m N/mm ²	A ₅ %	KV (20°C) J
> 450	530 - 610	> 23	≥ 120

APPROXIMATE CHEMICAL COMPOSITION OF THE ALL-WELD METAL

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

RECOMMENDED WELDING CURRENT

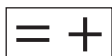
Ø mm	2,5	3,2	4,0	5,0
A	60 - 90	85 - 140	140 - 190	170 - 250

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

APPROVALS

DB; TÜV



Marking: **EZ - 55 B Mo**
Dry before use 2h/300°C