

EZ - 70 B

CLASSIFICATION

EN ISO 3580-A	AWS / ASME SFA-5.5
E Cr Mo1 B 42	E8018-B2

DESCRIPTION AND APPLICATION

Basic coated electrode alloyed with Cr and Mo. Suitable for welding of creep resisting steels with working temperatures up to 550°C. Also, it is 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 casts	Č 7400	13CrMo44 (1.7335)	13CrMo4-5
	Č 4732	42CrMo4 (1.7225)	42CrMo4
	Č 4730	25CrMo4 (1.7218)	25CrMo4
	Č 4720	15CrMo5 (1.7262)	18CrMo4
	ČL 4730	20CrMo4 (1.7321)	20MoCr5
	ČL 7431	16MnCr5 (1.7131)	16MnCr5
		GS-25 CrMo4 (1.7218)	G25CrMo4
	GS-24 CrMo 54 (1.7354)	G22CrMo5-4	
	GS-17 CrMo 55 (1.7357)	G17CrMo5-5	

MECHANICAL COMPOSITION OF THE ALL-WELD METAL

Stress relieved at 720°C.

R _{eL} N/mm ²	R _m N/mm ²	A ₅ %	KV (20°C) J
> 470	570 - 700	> 22	≥ 110

APPROXIMATE CHEMICAL COMPOSITION OF THE ALL-WELD METAL

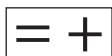
	C	Mn	Si	Cr	Mo
%	0,08	0,8	0,5	1,2	0,5

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 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



Marking: **E 8018-B2**
Dry before use 2h/300°C