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|--------------------------------|-----------------|-----------------|
| International standards | Material number | 1.7346 |
| | EN 1599 | E CrMo1 B 12 H5 |
| | AWS A 5.5 | E 8018-B2 |

Approvals TÜV, DB, CE

Typical applications and characteristics Basic coated CrMo alloy electrode for welding high-strength joints on low alloy tempered steels of up to 880 N /mm². Suitable for welding creep-resistant CrMo steels in boiler and piping system construction. Resistant to high temperatures up to 500°C. Non-ageing welding deposit, resistant to alkaline solutions, heat-treatable and case-harden able. The electrode should be welded with a short arc, preferably on the + pole; for root layers weld on the – pole with an air gap. Preheating and post weld heat treatment of base materials to be carried out acc. to the steel manufacturer's instructions.

Operating temperature Room temperature up to + 500° C

| | | |
|-----------------------|--------------------|------------------------|
| Base materials | 1.7218 25 CrMo 4 | 1.7218 GS- 25 CrMo 4 |
| | 1.7262 15 CrMo 5 | 1.7321 GS- 20 MoCr 4 |
| | 1.7321 20 MoCr 4 | 1.7354 GS- 22 CrMo 5 4 |
| | 1.7335 13 CrMo 4 4 | |

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|-----------------------------------------------------------------|-------------------------------------------------------------|------------------------------------------------------------|---------------------------------------|-----------------------------------|------------------------------------------------------------------------|
| Mechanical properties of all-weld metal (typical values) | Tensile strength R _m N/mm ² | Yield strength R _{eL} N/mm ² | Elongation A ₅ % | Impact strength ISO-V J | 1 Annealed 30 min. 720°C 2.Tempered 30 min. 930°C then 30 min 720°C |
| | 640 | 500 | 24 | 90 | 1. |
| | 530 | 370 | 26 | 120 | 2. |

| | | | | | |
|--------------------------------------------|----------|-----------|-----------|-----------|-----------|
| Weld metal analysis (typical, wt %) | C | Si | Mn | Cr | Mo |
| | 0.07 | 0.7 | 0.9 | 1.1 | 0.5 |

Current = +(-) / ~ 65 V

Welding positions PA, PB, PC, PD, PE, PF,

Rebaking 1 h. 350 °C + / - 10 °C (if necessary)

| Dia./Length | Amperage (A) | Pcs./packet | Pcs./carton | kg / 1000 | kg / packet | kg / carton |
|-------------|--------------|-------------|-------------|-----------|-------------|-------------|
| 2,5 x 350 | 70 - 110 | 234 | 935 | 21,4 | 5,0 | 20,0 |
| 3,2 x 350 | 95 - 150 | 138 | 552 | 36,2 | 5,0 | 20,0 |
| 4,0 x 350 | 130 - 190 | 91 | 364 | 54,9 | 5,0 | 20,0 |
| 5,0 x 450 | 150 - 240 | 54 | 218 | 110,2 | 6,0 | 24,0 |

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