

<b>International standards</b>	Material number	1.7346
	EN 1599	E CrMo1 B 12 H5
	AWS A 5.5	E 8018-B2

**Approvals** ---

**Typical applications and characteristics** Basic coated CrMo alloy electrode for welding high-strength joints on low alloy tempered steels of up to 880 N /mm<sup>2</sup>. 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

<b>Base materials</b>	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		

**Mechanical properties of all-weld metal (typical values)**

Tensile strength R <sub>m</sub> N/mm <sup>2</sup>	Yield strength R <sub>eL</sub> N/mm <sup>2</sup>	Elongation A <sub>5</sub> %	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