



Selectarc B60

High temperature
Basic coated Electrode

Classification

AWS A5.5 : E7018-A1 EN 1599 : E Mo B 4 2 H5
ISO 3580-A : E Mo B 4 2 H5

Description & Applications

Low hydrogen basic coated electrode with Mo for welding creep resisting steels used at temperatures up to 500°C. Good resistance to Hydrogen attacks (chemical installations). Used for piping systems, boilers. Soft fusion, easy slag removal and nice aspect of the metal deposit.

Base materials :

Steels and tube for pressure vessel and boiler :

NF A 36-206	:	15D3 - 18MD4 -05
DIN 17155-17245	:	HI - HIII - GS C 25 17 Mn4
DIN 17175-17102	:	19Mn5 - 15Mo3 - GS22Mo4 St35,8 – St 45,8 - 17Mn4 - 19Mn5 - 15Mo3 - StE255 - StE420
BS	:	BS 1504 Gr 245 BS 3100 Gr B1 BS 3606 Gr 243,245
ASTM	:	A335 Gr P1 - A352 GrLC1 - A204 GrA and B-A 155 Gr CM 65/70

Typical Weld Metal Composition (%)

C	Si	Mn	Mo	P	S	Fe
<0.10	0.4	0.8	0.5	<0.025	<0.025	Rem.

All Weld Metal Mechanical Properties *

R _e (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
>450	>550	>22	+20°C >100

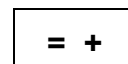
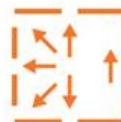
* After heat treatment at 650°C/1h

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x350	3,2x350	4,0x450	5,0x450
Current	(A)	80	115	150	190

Redrying: 2h at 350°C, if necessary. Interpass temperature: 100-250°C. Annealing after welding is advised at 650°C/1h.

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