

selectarc**B63SC****Basic coated Electrode
for creep resisting steels**


FSH WELDING GROUP
INNOVATIVE WELDING CONSUMABLES
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Classification

AWS A5.5 : E8018-B2
ISO 3580-A : E CrMo1 B 42 H5

EN 1599 : E CrMo1 B 42 H5
AWS A5.5M : E5518-B2H4

Description & Applications

Low hydrogen basic coated electrode alloyed with Cr and Mo for welding creep resisting steels with 1% Cr - 0.5% Mo. Resistant to high temperature up to 500-550°C. Soft fusion, good slag removal. Nice aspect of the weld bead. For piping systems, boilers, over heaters.

Main applications: petro-chemistry, chemical industry.

Base materials

Mat. N°	EN	DIN	NF	ASTM
1.7218	25CrMo4		25CD4	
1.7243	18CrMo4		18CD4	
1.7258		24CrMo5		
1.7335	13CrMo4-5	13CrMo4 4	15CD4.05	A182 Gr F11, F12 ; A387 Gr 12 A213/A250 Gr T12 ; A335 Gr P12 ; A336 Gr F12
1.7337		16 CrMo 4-4		A213/A250 Gr T11 ; A335 Gr P11
1.7350		22 CrMo 4 4		
1.7354	G22CrMo5-4	GS-22 CrMo 5 4		

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Mo	P	S	Bruscato
0.07	0.3	0.8	1.1	0.5	<0.012	<0.010	< 15ppm

All Weld Metal Mechanical Properties *

Re (MPa)	Rm (MPa)	A ₅ (%)	KV (J)
>480	>550	>20	+20°C >120

* After heat treatment at 680 °C / 2 h

Welding Current & Instructions

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

Redrying: 1h at 350°C, if necessary. Preheating of joints to weld: 200-250°C.

Interpass temperature: 150 -250°C. Annealing after welding is advised at 680 - 700°C/1-2h.



1G/PA



2F/PB



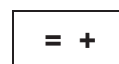
2G/PC



3G/PF



4G/PE



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