



Selectarc B69

*Basic coated Electrode
For creep resisting steels*

Classification

AWS A5.5 : E8018-B6 EN 1599 : E CrMo5 B 4 2 H5
ISO 3580-A : E CrMo5 B 4 2 H5

Description & Applications

Low hydrogen basic coated electrode with Cr and Mo for welding steels of similar chemical composition. Deposit resisting to temperature and creep up to 600°C. Highly resistant to hot gas and overheated steam.

Main applications: For heat exchangers, tubes, steam boilers, overheaters...

Base materials :

Tubes & steels for boiler and pressure vessels:

EN	:	17 CrMo 3 5 – 12 CrMo 19 5 – G X12 CrMo5
Material N°	:	1.7332 – 1.7362 – 1.7363
ASTM	:	A387 Gr 5Cl1 et 2 – A199 Gr T5 – A182 Gr F5 – A213 G T5 A335 Gr P5 – A336 Gr F5 – A369 GrF5 – A217 Gr C5
EN	:	17 CrMo 3 5 – 12 CrMo 19 5 – G X12 CrMo5

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Mo	P	S	Fe
<0.10	0.4	0.8	5.0	0.5	<0.025	<0.025	Rem.

All Weld Metal Mechanical Properties *

R _e (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
>420	>590	>20	+20°C >70

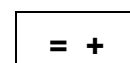
* After heat treatment at 730°C/2h

Welding Current & Instructions

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

Redrying: 1h at 300°C, if necessary. Preheating of joints to weld at 300°C. Interpass temperature: 250-350°C. Annealing after welding is advised at 730°C/2h, then slow cooling (maxi 55°C/h, until 580°C, followed by cooling at calm air).

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