



Selectarc B70

High Strength
Basic Electrode

Classification

AWS A 5.5 : E10018-G ISO 18275-A : E 62 5 1,5NiMo B 4 2 H5

Description & Applications

Basic coated electrode highly resistant to cracks and elaborated for welding fine grain steels and steels with high mechanical strength (R_m up to 800 MPa). Welds of high security, buffer layers before hardfacing. Regular fusion, stable arc, low spatters, good removal of the slag and nice aspect of the weld seam.

Base materials Construction steels for general use:

NF A 35-501	:	A50-2*. A60-2*,3. E36-2*,3*,4*.
DIN 17100	:	St50-2*. St60-2*. St70-2*.
ASTM	:	A 678grC*. A709gr50*,100*. A710gr A.
High strength steels	:	
NF A 36-204	:	E500T*. E550T*. E620T*. E690T*.
DIN 17102	:	StE460, 500*, 590*,690*.

Also suitable for welding heat- treatable steels like: 15CD4*. 25CD4*. 35CD4*. XC38. XC48*. 32C4 , also for construction steels self-patinng (consult us)

* Eventual preheating and post-weld heat treatment in the case of heavy thickness.

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	Mo	Fe
<0.10	0.5	1.4	0.2	1.5	0.4	Rem.

All Weld Metal Mechanical Properties

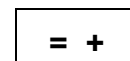
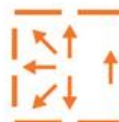
R_e (MPa)	R_m (MPa)	A_5 (%)	KV (J)	
>620	720-820	>22	+20°C	>130
			-20°C	>90
			-50°C	>50

Welding Current & Instructions

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

Redrying at 350°C during 2 hours. Eventual preheating depends on the thickness and the nature of the steel (100°C). Interpasses temperature <200°C. A stress relieving heat treatment is advised in most cases, at 600°C during 2 hours.

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