Selectarc B75Cu

Basic Electrode

For steels resistant to Atmospheric corrosion

Classification

AWS A 5.5 : E8018-W2 EN 499 : E 46 2 Z B 4 2 H5
ISO 2560-A : E 46 2 Z B 4 2 H5

Description & Applications

Low hydrogen basic coated electrode with a steel deposit containing Cu- Ni- Cr, for welding all steels resistant to atmospheric corrosion (industrial, sea, rural). Regular fusion, good removal of the slag. Nice aspect of the weld seams.

Main applications: Public buildings, department of civil engineering, navy, tanks, water tower, bridges, crash barrier, electrical pylons.

Base materials

Steels with improved resistance to atmospheric corrosion:

NF A 35-502	:	E24W Quality 2 to 4 , E36W A2-A4
DIN	:	WT St37-2 , WT St37-3 , WT St52
Trade marks	:	COR-TEN A,B,C – PATINAX – INDATEN – ACOR…

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	Cu	P	S	Fe
<0.10	0.4	1.0	0.5	0.5	0.4	<0.025	<0.025	Rem.

All Weld Metal Mechanical Properties

R_e (MPa)	R_m (MPa)	A_5 (%)	KV (J)
>460	>550	>19	-20°C >60

Welding Current & Instructions

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

Rebaking of the electrodes at 350°C during 1 hour.

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