

# selectarc B78

**High Strength  
Basic Electrode**



## Classification

AWS A5.5 : E12018-M      EN 757 : E 69 4 Mn2NiCrMo B 42 H5

## Description & Applications

Basic coated electrode highly resistant to cracks and elaborated for welding high strength fine grain steels (Rm up to 900 MPa).

Welds of high security, very low hydrogen-content HD < 5ml/100g.

Regular fusion, stable arc, low spatters, good removal of the slag and nice aspect of the weld seam.

**Base materials**      High strength low alloy steels

EN- Designation	S890	
DIN 17102	E620T*; E690T*	StE690* ; StE 890
	15NiCrMo10-6	(G19NiCrMo12-6)
ASTM	1.6780	(1.6783)
	HY80	

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

## Typical Weld Metal Composition ( % )

C	Si	Mn	Ni	Cr	Mo	P	S
0.06	0.4	1.5	2.1	0.4	0.5	<0.025	<0.025

## All Weld Metal Mechanical Properties

Rp0,2 ( MPa )	Rm ( MPa )	A5 ( % )	KV ( J )
> 750	> 830	> 18	+20°C 100 -40°C 50

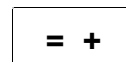
## Welding Current & Instructions

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 2 hours. Eventual preheating depends on the thickness and the nature of the steel (50 - 130°C). Interpass temperature <150°C.



1G/PA    2F/PB    2G/PC    3G/PF    4G/PE



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