



Selectarc B58

Basic Low Hydrogen Electrode

Classification

AWS A5.1 : E7018 ISO 2560-A : E 42 4 B 3 2 H5
AWS A5.1M : E49 18 – H8

Description & Applications

Universal basic coated, low hydrogen (with iron powder, recovery 118%) electrode for welding highly stressed connections with high security. Good low temperature properties down to -40°C and to cold cracks. Stable arc, regular weld beads, and slag easy to remove.

Main applications: For frames, cases, supports, ship building, pressure vessels.

Base materials

Construction steels for general use, Tube steels, Ship steels, Steels for Boiler and Pressure Vessels, High strength steels, Heat resisting steels, Cold tough steels

EN-Designation	S185 – S355 GP240R L210 – L360	P235 – P355 P235GH – P265GH
Ship steels	Quality A, B, C and D	
ASTM	A285 grade C A442 grade 55 , 60 A516 grade 55 , 60 , 65 ,70	A414 grade C, D, E, F A515 grade 55, 60, 65, 70

Typical Weld Metal Composition (%)

C	Si	Mn	P	S	Fe
0.07	0.5	1.4	<0.02	<0.02	Rem.

All Weld Metal Mechanical Properties

R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)	
480	580	28	-20°C	180
			-40°C	70

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x350	3,2x350	4,0x450	5,0x450
Intensité	(A)	70-90	90-120	130-180	170-220

Redrying 2h at 300°C, if necessary. Interpass temperature: <250°C.

ind.12.1



= + ~ 65V

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