



# Selectarc B609

*Basic coated Electrode  
For creep resisting steels*

## Classification

AWS A5.5 : E8016-B8      EN 1599 : E CrMo9 B 4 2 H5  
ISO 3580-A : E CrMo9 B 4 2 H5      AWS A5.4 : E505-15

## Description & Applications

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

**Main applications:** For power plants, heat exchangers, tubes, steam boilers,...

**Base materials :**

**Tubes & steels for boiler and pressure vessels:**

ASTM	DIN	N° de Mat.
A 217 grade C12	X12 CrMo 9-1	1.7386
A 335 grade P9	G-X 12 CrMo 10 1	1.7389
A 199 , 200, 213 grade T9		

## Typical Weld Metal Composition ( % )

C	Si	Mn	Cr	Mo	P	S	Fe
<0.10	0.4	0.8	9.0	1.0	<0.025	<0.025	Rem.

## All Weld Metal Mechanical Properties \*

R <sub>e</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )	KV ( J )
>500	>650	>19	+20°C >60

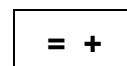
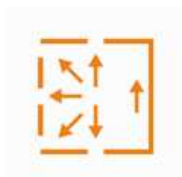
\* After heat treatment at 750°C/1h

## Welding Current & Instructions

Electrode	ØxL ( mm )	2,5x300	3,2x350	4,0x450
Current	( A )	80	115	150

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 750°C/ 1h, then slow cooling (maxi 55°C/h, until 580°C, followed by cooling at calm air).

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