# Selectarc B63

*Basic coated Electrode*
*For creep resisting steels*

## Classification

AWS A5.5 : E8018-B2 EN 1599 : E CrMo1 B 4 2 H5
ISO 3580-A : E CrMo1 B 4 2 H5

## Description & Applications

Low hydrogen basic coated electrode alloyed with Cr and Mo for welding creep resisting steels with 1% Cr - 0.5% Mo. Resistant to high temperature up to 500-550℃. For piping systems, boilers, overheaters. Soft fusion, good slag removal. Nice aspect of the weld bead.

**Main applications:** Petrochemistry, chemical industry.

**Base materials :**

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

| | | |
|---|---|---|
| EN | : | 15Cr3 – 16 MnCr 5 – 20 MnCr 5 – 24 CrMo 5 – 15 CrMo 5<br>13 CrMo 4 4 - 22 CrMo 4 4 – GS 17 CrMo 5 5 |
| Material N° | : | 1.7015 – 1.7131 – 1.7147 – 1.7223 – 1.7225 – 1.7258<br>1.7262 – 1.7335 – 1.7337 – 1.7350 – 1.7357 |
| ASTM | : | A335 Gr.P12 – A387 Gr.12Cl2 – A193 Gr B7 – A182 Gr F11<br>A336 Gr F12 – A217 Gr WC6 |

## Typical Weld Metal Composition ( % )

| C | Si | Mn | Cr | Mo | P | S | Fe |
|---|---|---|---|---|---|---|---|
| <0.12 | 0.4 | 0.8 | 1.1 | 0.5 | <0.025 | <0.025 | Rem. |

## All Weld Metal Mechanical Properties *

| $R_e$ ( MPa ) | $R_m$ ( MPa ) | $A_5$ ( % ) | KV ( J ) |
|---|---|---|---|
| >460 | >550 | >19 | +20℃ >120 |

* After heat treatment at 700℃/1h

## Welding Current & Instructions

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

Redrying: 1h at 350℃, if necessary. Preheating of joints to weld: 200-250℃. Interpass temperature: 150-250℃. Annealing after welding is advised at 70 0℃/1-2h.

Ind.12

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