



Selectarc B63

*Basic coated Electrode
For creep resisting steels*

Classification

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

EN 1599 : 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°C. 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 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 1.7262 – 1.7335 – 1.7337 – 1.7350 – 1.7357
ASTM	: A335 Gr.P12 – A387 Gr.12Cl2 – A193 Gr B7 – A182 Gr F11 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°C >120

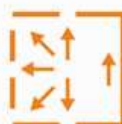
* After heat treatment at 700°C/1h

Welding Current & Instructions

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

Redrying: 1h at 350°C, if necessary. Preheating of joints to weld: 200-250°C. Interpass temperature: 150-250°C. Annealing after welding is advised at 700°C/1-2h.

Ind.12



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