



Selectarc B69

*Basic coated Electrode
For creep resisting steels*

Classification

AWS A5.5 : E8018-B6
ISO 3580-A : E CrMo5 B 4 2 H5

EN 1599 : E CrMo5 B 4 2 H5

Description & Applications

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

Main applications: For heat exchangers, tubes, steam boilers, overheaters...

Base materials :

Tubes & steels for boiler and pressure vessels:

| | | |
|-------------|---|----------------------------------------------------------------------------------------------------------------|
| EN | : | 17 CrMo 3 5 – 12 CrMo 19 5 – G X12 CrMo5 |
| Material N° | : | 1.7332 – 1.7362 – 1.7363 |
| ASTM | : | A387 Gr 5Cl1 et 2 – A199 Gr T5 – A182 Gr F5 – A213 G T5 A335 Gr P5 – A336 Gr F5 – A369 GrF5 – A217 Gr C5 |
| EN | : | 17 CrMo 3 5 – 12 CrMo 19 5 – G X12 CrMo5 |

Typical Weld Metal Composition (%)

| C | Si | Mn | Cr | Mo | P | S | Fe |
|-------|-----|-----|-----|-----|--------|--------|------|
| <0.10 | 0.4 | 0.8 | 5.0 | 0.5 | <0.025 | <0.025 | Rem. |

All Weld Metal Mechanical Properties *

| R _e (MPa) | R _m (MPa) | A ₅ (%) | KV (J) |
|------------------------|------------------------|----------------------|-----------|
| >420 | >590 | >20 | +20°C >70 |

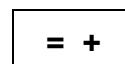
* After heat treatment at 730°C/1h

Welding Current & Instructions

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

Redrying: 1h at 300°C, if necessary. Preheating of joints to weld at 300°C. Interpass temperature: 250-350°C. Annealing after welding is advised at 730°C/1h, then slow cooling (maxi 55°C/h, until 580°C, followed by cooling at calm air).

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