



# Selectarc B70

High Strength  
Basic Electrode

## Classification

AWS A 5.5 : E10018-G

ISO 18275-A : E 62 5 1,5NiMo B 4 2 H5

## Description & Applications

Basic coated electrode highly resistant to cracks and elaborated for welding fine grain steels and steels with high mechanical strength ( $R_m$  up to 800 MPa). Welds of high security, buffer layers before hardfacing. Regular fusion, stable arc, low spatters, good removal of the slag and nice aspect of the weld seam.

### Base materials

#### Construction steels for general use:

NF A 35-501	:	A50-2*. A60-2*,3. E36-2*,3*,4*.
DIN 17100	:	St50-2*. St60-2*. St70-2*.
ASTM	:	A 678grC*. A709gr50*,100*. A710gr A.

#### High strength steels :

NF A 36-204	:	E500T*. E550T*. E620T*. E690T*.
DIN 17102	:	StE460, 500*, 590*,690*.

Also suitable for welding heat- treatable steels like: 15CD4\*. 25CD4\*. 35CD4\*. XC38. XC48\*. 32C4 , also for construction steels self-patining (consult us)

\* Eventual preheating and post-weld heat treatment in the case of heavy thickness.

## Typical Weld Metal Composition ( % )

C	Si	Mn	Cr	Ni	Mo	Fe
<0.10	0.5	1.4	0.2	1.5	0.4	Rem.

## All Weld Metal Mechanical Properties

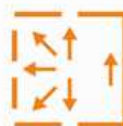
$R_e$ ( MPa )	$R_m$ ( MPa )	$A_5$ ( % )	KV ( J )	
>620	720-820	>22	+20°C	>130
			-20°C	>90
			-50°C	>50

## Welding Current & Instructions

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

Redrying at 350°C during 2 hours. Eventual preheating depends on the thickness and the nature of the steel (100°C). Interpasses temperature <200°C. A stress relieving heat treatment is advised in most cases, at 600°C during 2 hours.

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