



Selectarc B73

High Strength
Basic Electrode

Classification

AWS A5.5 : E9018-D1

ISO 18275-A : E 55 4 MnMo B 4 2 H5

Description & Applications

Low hydrogen basic coated electrode with high yield strength for welding fine grain steels applied at temperatures between -50 to +500°C. Thermal treated low alloyed steels with C-Mn. Resistant to fatigue - corrosion in the presence of phosphorus and sulphur. Soft fusion, easy slag removal, nice aspect of weld seam.

Base materials

Construction steels for general use:

NF A 35-501	:	A50.2 A60.2.
DIN 17100	:	St60-2. St 70-2.

Steels for boiler and pressure vessels:

NF A36-207	:	A550AP, FP. A590AP, PP
NF A36-205	:	A37 CP, AP, FP.
DIN 17155	:	HI to HIV, 19 Mn6, 19Mn5, 17Mn4

High strength steels

DIN 17102	:	StE255 to 380.
Heat resisting steels	:	WstE255 to 380
Cold tough steels	:	TstE255 to 380.

Typical Weld Metal Composition (%)

C	Si	Mn	Mo	Fe
<0.10	0.5	1.5	0.4	Rem.

All Weld Metal Mechanical Properties

R _e (MPa)	R _m (MPa)	A ₅ (%)	KV (J)	
540-600	630-710	>18	+20°C	>150
			-40°C	>50
			-50°C	>30

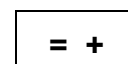
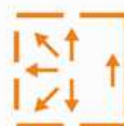
After stress relieving at 620°C/1h

Welding Current & Instructions

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

Preheating of the base metal is recommended (150°C) . Interpass temperature: < 250°C. Thermal stress relieving depending on the thickness of welded pieces (620°C).

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