Selectarc B74

High Strength
Basic Electrode

Classification

AWS A5.5 : E8018-G ISO 18275-A : E 50 2 Mo B 4 2 H5

Description & Applications

Low hydrogen basic coated electrode with increased yield strength for welding fine grain steels applied at temperatures between -40 to +500°C. Thermal treated low alloyed steels with C-Mn. Soft fusion, easy slag removal, nice aspect of weld seam.

Base materials: **Construction steels for general use. Tube steels, Steels for Boiler and Pressure Vessels. High strength steels, Heat resisting steels, Cold tough steels.**

EN-Designation	S355 – S500	P355 – P460
	20 MnMoNi5-5; 17MnMoV6-4	15NiCuMoNb5 ; 22NiMoCr4-7
ASTM	A225 grade C	A302 grade A - D
	A514 grade A – C	A517 grade A – C

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	Mo	Cu	Nb	P	S	V	Fe
0.06	0.3	1.2	<0.10	0.2	0.4	<0.10	<0.01	<0.02	<0.02	<0.02	Base

All Weld Metal Mechanical Properties

R_e (MPa)	R_m (MPa)	A_5 (%)	KV (J)
560	640	22	+20°C 160 -20°C >70

Welding Current & Instructions

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

Redrying 2 h at 300 °C. Preheating of the base metal is recommended at 150°C. Interpass temperature: < 250°C. Thermal stress relieving depending on the thickness of welded pieces (620°C/1h).

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