



Selectarc B75Cu

Basic Electrode

For steels resistant to atmospheric corrosion

Classification

AWS A 5.5 : E8018-W2

ISO 2560-A : E 50 4 Z B 4 2 H5

Description & Applications

Low hydrogen basic coated electrode with a steel deposit containing Cu, Ni and Cr, for welding all steels resistant to atmospheric corrosion (industrial, sea, rural). Regular fusion, good slag removal, nice aspect of the weld beads.

Main applications: Public buildings, department of civil engineering, navy, tanks, water tower, bridges, crash barrier, electrical pylons.

Base materials

Steels with improved resistance to atmospheric corrosion:

NF A 35-502	:	E24W Quality 2 to 4 , E36W A2-A4
DIN	:	WT St37-2 , WT St37-3 , WT St52
Trade marks	:	COR-TEN A,B,C – PATINAX – INDATEN – ACOR...

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	Cu	P	S	Co	O/T
0.06	0.40	1.1	0.55	0.60	0.40	0.015	0.010	0.02	<0.50

All Weld Metal Mechanical Properties

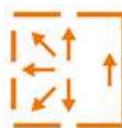
R _e (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
580	660	22	-20°C 100 -40°C 70

Welding Current & Instructions

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

Electrode redrying : 350°C/1h.

FT En-835-200709



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