# 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<br>-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.

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