Selectarc B79EH

Very High Strength
Basic Electrode

Classification

AWS A5.5 : E12018-G ISO 18275-A : E 89 4 Z Mn2NiCrMo B 4 2 H5

Description & Applications

Basic coated electrode with low hydrogen content (<5 ml/100g), very high tensile strength (Rm ~1000 MPa) and resistant to cracks. Weld deposit with Chromium, Nickel and Molybdenum for welding of fine grain steels and steels with increased yield strength. Regular fusion, stable arc, low spatters, good removal of the slag and nice aspect of the weld bead.

Base materials:

Construction steels for general use and high strength low alloy steels:

EN	*ASTM*
S690Q-S890Q,	HY100
S690QL-S890QL	HY80
S690QLN-S890QLN	API 5AL80

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	Mo	Cu	Nb	V	P	S
0.08	0.4	1.8	0.6	1.9	0.8	0.06	0.005	0.005	0.015	0.010

Typical All Weld Metal Mechanical Properties

R_e (MPa)	R_m (MPa)	A_5 (%)	KV (J)
900	1000	16	+20°C 75
			-40°C 50

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x350	3,2x350	4,0x450	5,0x450
Current	(A)	90	120	150	190

Redrying 2h at 350 °C. Eventual preheating dependind on the thickness and nature of the steel (100°C). Interpass temperature: ~150°C.

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