Selectarc B82

Basic Electrode
For cold tough steels

Classification

AWS A5.5 : E8018-C1 EN 499 : E 46 6 2Ni B 4 2 H5
ISO 2560-A : E 46 6 2Ni B 4 2 H5

Description & Applications

Low hydrogen basic coated electrode alloyed with Nickel for welding cold tough fine grain steels (steels with Nickel, heat treated steels) applied at low temperature -60°C. Good characteristics of cold toughness.

Main applications : For liquid gas distribution pipes, tanks, off shore, and petrochemistry.

Base materials

Fine grain construction steels, cold tough:

NF A 36-204	:	E420T – E460T
NF A 36-205	:	A37FP – A42FP – 48FP – A52FP
NF A 36-207	:	A510FP1 – A550FP2
NF A 36-208	:	0.5 Ni 285 and 355 (10N2) – 1.5 Ni 285 and 355 (15N6)
DIN 17102	:	TStE 255 to TStE 420
DIN 17780	:	14Ni6 – 10Ni14 – 11MnNi5.3 – 12MnNi6.3 – 13MnNi6.3.
ASTM	:	A203Cr A and B – A352CrLC2 – A334Cr7 – A714Cr 1 à 6
		A707Cr L4 à L6 – A662Cr A and B

Typical Weld Metal Composition (%)

C	Si	Mn	Ni	P	S	Fe
<0.12	0.4	1.0	2.5	<0.025	<0.025	Rem.

All Weld Metal Mechanical Properties

R_e (MPa)	R_m (MPa)	A_5 (%)	KV (J)
>460	>550	>19	-40°C >70 -60°C >30 -73°C >27

Welding Current & Instructions

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

Redrying at 350 °C during 1 hour if necessary. Eventual preheating of the welding joints (above 100 °C), in the case of heavy thickness.

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