# Selectarc B842

*Basic Electrode*
*For cold tough steels*

## Classification

AWS A5.5 : E7018-G EN 499 : E 42 6 1Ni B 4 2 H5
ISO 2560-A : E 42 6 1Ni B 4 2 H5

## Description & Applications

Low hydrogen basic coated electrode alloyed with Nickel for welding steels with high strength and high toughness, resistant to low temperature down to -60℃. Used for weld joints exposed to low temperature . Regular fusion, nice aspect of the deposit.

**Base materials**

**Fine grain construction steels, cold tough:**

| | |
|---|---|
| EN : | S185 – S355 – P235GH – P355 – L210 – L415 – S/P275 – S/P460 - E295 – E335 – E360 – P295GH – P355GH – P235 – P265 – A St35 – A St52 – GP240R. |
| ASTM : | A302 Gr A, B, C, D – A333 Gr 126 – A414 Gr G – A487 Gr BQ CQ A521 Gr AA, AB, CE, CF, LF1 – A537 C12 – A572 Gr 60&65 A350 Gr 126 – A350 Gr LF1, LF2 – A607 Gr 60&65 – A633 Gr A&B LF5 A668 Gr E&F – A714 Gr I à VI |

## Typical Weld Metal Composition ( % )

| C | Si | Mn | Ni | P | S | Fe |
|---|---|---|---|---|---|---|
| 0.06 | 0.4 | 1.2 | 0.9 | <0.025 | <0.020 | Rem. |

## All Weld Metal Mechanical Properties

| $R_{p0.2}$ ( MPa ) | $R_m$ ( MPa ) | $A_5$ ( % ) | KV ( J ) |
|---|---|---|---|
| >470 | 550-680 | >22 | -60℃ 50 |

## Welding Current & Instructions

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

Redrying at 300℃ during 2h, if necessary. Eventual preheating of the weld joint at 100℃. Interpass temperature: <250℃. A thermal stress relieving hea t treatment is advised at 550℃ during 1-2 hours.

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