



Selectarc B63SC

*Basic coated Electrode
For creep resisting steels*

Classification

AWS A5.5 : E8018-B2

ISO 3580-A : E CrMo1 B 4 2 H5

Description & Applications

Low hydrogen basic coated electrode alloyed with Cr and Mo for welding creep resisting steels with 1% Cr - 0.5% Mo and Bruscato/X-factor < 15ppm. Resistant to high temperature up to 500-550°C. For piping systems, boilers, overheaters. Soft fusion, good slag removal. Nice aspect of the weld bead.

Main applications: Petrochemistry, chemical industry.

Base materials:

Tube & steels for boiler and pressure vessels :

EN	: 25CrMo4 – 18CrMo4 – 13CrMo4-5 – G22CrMo5-4
Material Nr.	: 1.7218 – 1.7243 – 1.7258- 1.7335 – 1.7337 – 1.7350 – 1.7354
ASTM	: A182 Gr F11 – A182 Gr F12 – A387 Gr 12 – A213/A250 Gr T12 – A335 Gr P12 – A336 Gr F12 – A213/A250 Gr T11 – A335 Gr P11

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Mo	Ni	Cu	Nb	P	S	Co	As	Sn	Sb
0.07	0.20	0.80	1.10	0.50	0.02	0.05	0.005	0.010	0.007	0.01	0.004	0.002	0.002

X-factor: <15 ppm

All Weld Metal Mechanical Properties *

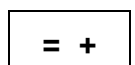
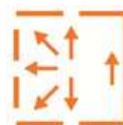
R_e (MPa)	R_m (MPa)	A_5 (%)	KV (J)
>460	>550	>20	+20°C >120

* After heat treatment at 690°C/1h

Welding Current & Instructions

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

Redrying: 2h at 300°C, if necessary. Preheating of joints to weld: 190°C. Interpass temperature: 160-190°C. Post weld heat treatment is advised at 690°C for 1 or 2h.



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