



Selectarc B56S

Universal Basic Electrode

Classification

AWS A5.1 : E7018-1 EN 499 : E 42 4 B 3 2 H5
 ISO 2560-A : E 42 4 B 3 2 H5

Description & Applications

Universal basic coated electrode (115% recovery) for welding highly stressed connections with high security. Good low temperature properties down to -50°C. Resistant to cold cracks. Slag easy to remove. For frames, cases, supports, ship building, pressure vessels.

Base materials **Construction steels for general use, Tube steels, Ship steels, Steels for Boiler and Pressure Vessels, High strength steels, Heat resisting steels, Cold tough steels**

EN-Designation	S185 – S355 GP240R	P235 – P355 P235GH – P265GH
	L210 – L360	
Ship steels	Quality A, B, C and D	
ASTM	A285 grade C A442 grade 55 , 60 A516 grade 55 , 60 , 65 ,70	A414 grade C, D, E, F A515 grade 55 , 60 , 65 , 70

Typical Weld Metal Composition (%)

C	Si	Mn	P	S	Fe
<0.10	0.4	1.1	<0.025	<0.025	Rem.

All Weld Metal Mechanical Properties

R _e (MPa)	R _m (MPa)	A ₅ (%)	KV (J)	
>420	510-610	>22	+20°C	>120
			-20°C	>70
			-50°C	>40

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x350	3,2x350	3,2x450	4,0x450	5,0x450
Current	(A)	65-100	95-140	95-140	135-180	160-250

Redrying: 2h at 300°C, if necessary. Interpass temperature: <250°C.

Ind.12



= +	~ 70V
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