



Selectarc B58

Basic Low Hydrogen Electrode

Classification

AWS A5.1 : E7018 ISO 2560-A : E 42 4 B 3 2 H5
 AWS A5.1M : E49 18 – H8

Description & Applications

Universal basic coated, low hydrogen (with iron powder, recovery 118%) electrode for welding highly stressed connections with high security. Good low temperature properties down to -40°C and to cold cracks. Stable arc, regular weld beads, and slag easy to remove.

Main applications: 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 L210 – L360	P235 – P355 P235GH – P265GH
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
0.07	0.5	1.4	<0.02	<0.02	Rem.

All Weld Metal Mechanical Properties

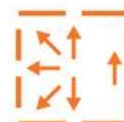
R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)	
480	580	28	-20°C	180
			-40°C	70

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x350	3,2x350	4,0x450	5,0x450
Intensité	(A)	70-90	90-120	130-180	170-220

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

ind.12.1



= + ~ 65V

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