



# Selectarc B60

High temperature  
Basic coated Electrode

## Classification

AWS A5.5 : E7018-A1      EN 1599 : E Mo B 4 2 H5  
ISO 3580-A : E Mo B 4 2 H5

## Description & Applications

Low hydrogen basic coated electrode with Mo for welding creep resisting steels used at temperatures up to 500°C. Good resistance to Hydrogen attacks (chemical installations). Used for piping systems, boilers. Soft fusion, easy slag removal and nice aspect of the metal deposit.

### Base materials :

### Steels and tube for pressure vessel and boiler :

|                 |   |   |
|-----------------|---|---|
| NF A 36-206     | : | 15D3 - 18MD4 -05  |
| DIN 17155-17245 | : | HI - HIII - GS C 25 17 Mn4  |
| DIN 17175-17102 | : | 19Mn5 - 15Mo3 - GS22Mo4 St35,8 – St 45,8<br>- 17Mn4 - 19Mn5 - 15Mo3 - StE255 - StE420 |
| BS              | : | BS 1504 Gr 245 BS 3100 Gr B1 BS 3606<br>Gr 243,245                                    |
| ASTM            | : | A335 Gr P1 - A352 GrLC1 - A204 GrA and<br>B-A 155 Gr CM 65/70                         |

## Typical Weld Metal Composition ( % )

| C     | Si  | Mn  | Mo  | P      | S      | Fe   |
|-------|-----|-----|-----|--------|--------|------|
| <0.10 | 0.4 | 0.8 | 0.5 | <0.025 | <0.025 | Rem. |

## All Weld Metal Mechanical Properties \*

| R <sub>e</sub> ( MPa ) | R <sub>m</sub> ( MPa ) | A <sub>5</sub> ( % ) | KV ( J )   |
|------------------------|------------------------|----------------------|------------|
| >450                   | >550                   | >22                  | +20°C >100 |

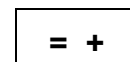
\* After heat treatment at 650°C/1h

## Welding Current & Instructions

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

Redrying: 2h at 350°C, if necessary. Interpass temperature: 100-250°C. Annealing after welding is advised at 650°C/1h.

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