



Selectarc B72

High Strength
Basic Electrode

Classification

AWS A5.5 : E9018-G

ISO 18275-A : E 55 5 1NiMo B 4 2 H5

Description & Applications

Low hydrogen basic coated electrode with a deposit which has a high yield strength and is very tough. Particularly recommended for root passes on fine grain steels resistant to a tensile strength between 550 and 700 MPa (ex : rails of travelling crane...).

Base materials

Construction steels for general use:

DIN 17100 : St50 - St52 - St60-2.

High strength steels :

NF A 36-207 : A550AP, FP – A590AP,FP

NF A 36-210 : 16MND5

ASTM A202 Gr A & B – A236 F & B – A238GrB – A486Gr90

A607Gr70 – A615Gr60 – A706 Gr60.

DIN : StE355 to WStE500

17MnMoV6.4 – 15NiCrMo10.6

N-AXTRA55, N-AXTRA60 (Thyssen)

API : X65 - X70

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	Mo	Fe
<0.10	0.5	1.2	0.1	0.8	0.3	Rem.

All Weld Metal Mechanical Properties

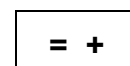
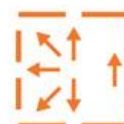
R _e (MPa)	R _m (MPa)	A ₅ (%)	KV (J)	
>530	>620	>20	+20°C	>150
			-50°C	>50
			-60°C	>28

Welding Current & Instructions

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

Redrying at 350°C during 2 hours. Eventual preheating depends on the nature and the thickness of the steel (100°C). Interpass temperature <200°C. A thermal stress relieving is advised in most cases at 600°C during 2 hours

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