



Selectarc B74

*High Strength
Basic Electrode*

Classification

AWS A5.5 : E8018-G

ISO 18275-A : E 50 2 Mo B 4 2 H5

Description & Applications

Low hydrogen basic coated electrode with increased yield strength for welding fine grain steels applied at temperatures between -40 to +500°C. Thermal treated low alloyed steels with C-Mn. Soft fusion, easy slag removal, nice aspect of weld seam.

Base materials:

Construction steels for general use. Tube steels, Steels for Boiler and Pressure Vessels. High strength steels, Heat resisting steels, Cold tough steels.

EN-Designation	S355 – S500 20 MnMoNi5-5; 17MnMoV6-4	P355 – P460 15NiCuMoNb5 ; 22NiMoCr4-7
ASTM	A225 grade C A514 grade A – C	A302 grade A - D A517 grade A – C

Typical Weld Metal Composition (%)

C	Si	Mn	Ni	Mo	P	S	Fe
0.04	0.4	1.4	0.2	0.5	<0.02	<0.02	Rem.

All Weld Metal Mechanical Properties

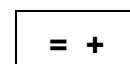
R _e (MPa)	R _m (MPa)	A ₅ (%)	KV (J)	
570	650	25	+20°C	160
			-30°C	60

Welding Current & Instructions

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

Redrying 2 h at 300 °C. Preheating of the base metal is recommended at 150°C. Interpass temperature: < 250°C. Thermal stress relieving depending on the thickness of welded pieces (620°C/1h).

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