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