Selectarc B68

Basic coated Electrode
For creep resisting steels

Classification

AWS A5.5 : E9018-B3 EN 1599 : E CrMo2 B 4 2 H5
ISO 3580-A : E CrMo2 B 4 2 H5

Description & Applications

Low hydrogen basic coated electrode alloyed with Cr and Mo for welding creep resisting steels used in service up to 600°C (including 2%Cr -1%Mo castings). High resistance to H_2S, ...

Main applications: For overheaters, valve bodies, pipes, boilers, hydrocrackers.

Base materials :

Tubes & steels for boiler and pressure vessels:

NF A 36-206	:	15CD4-05 – 10CD9-10
DIN 17155 and 17245	:	10 Cr Mo 9.10 – 10 Cr Si Mo V7
	:	24 CrMo V55 – 12 Cr Mo 9.10 GS 12 Cr MO 9.10…
BS	:	1501 Gr 622 to 1504 Gr 622, BS 359 Gr 622/640 1503 Gr 660, 1504Gr 660
ASTM	:	A 387 GrD – A 335 GrP 22 – A 213 GrT 22, T36

Grade Vallourec: Chromesco 3

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Mo	P	S	Fe
0.07	0.4	0.8	2.25	1.0	<0.025	<0.025	Rem.

All Weld Metal Mechanical Properties *

R_e (MPa)	R_m (MPa)	A_5 (%)	KV (J)
>450	>570	>17	+20°C >100

* After heat treatment at 700°C/1h

Welding Current & Instructions

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

Redrying: 1h at 300°C, if necessary. Preheating of joints to weld at 250°C. Interpass temperature: 150-300°C. Annealing after welding is advised at 700-750°C/1h.

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