Selectarc B84

Basic Electrode
With high toughness

Classification

AWS A5.5 : E8018-C2 EN 499 : E 46 6 3Ni B 4 2 H5
ISO 2560-A : E 46 6 3Ni B 4 2 H5

Description & Applications

Low hydrogen basic coated electrode alloyed with Nickel (above 3%) for welding fine grain steels used at low temperature (-60 to -80°C).

Main applications: Cryogenic and petrochemical industries. Storage and distribution of liquid gas or products volatile.

Base materials

Plates and tubes of fine grain steels, cold tough:

NF A 35-207	:	A510FP1 – A550FP2
NF A 36-208	:	3.5 Ni 285 and 355 (12N14)
DIN	:	10Ni14 – 14Ni6 – 16Ni14
ASTM	:	A203G D&E – A352GrLC3 – A334Gr3 – A350Gr LF3

Typical Weld Metal Composition (%)

C	Si	Mn	Ni	P	S	Fe
<0.10	0.3	0.9	3.5	<0.025	<0.025	Rem.

All Weld Metal Mechanical Properties

R_e (MPa)	R_m (MPa)	A_5 (%)	KV (J)
>460	>550	>19	-73°C >80
			-100°C >30

*After thermal stress relieving at 620°C/1h

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, if necessary. An eventual preheating depends on the thickness of the parent metal. A stress relieving heat treatment is recommended in most of cases (620°C/1h).

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