



B75Cu (DC+)

LOW ALLOY STEEL

DESCRIPTION

Low hydrogen basic coated electrode with a steel deposit containing Cu- Ni- Cr, for welding all steels resistant to atmospheric corrosion (industrial, sea, rural). Regular fusion, good removal of the slag. Nice aspect of the weld seams.

CLASSIFICATION

AWS A5.5 : E8018-W2 EN 499 : E 46 2 Z B 42 H5 ISO 2560-A : E 46 2 Z B 42 H5

TYPICAL APPLICATIONS

Public buildings, department of civil engineering, navy, tanks, water tower, bridges, crash barrier, and electrical pylons.

BASE MATERIALS

Steels with improved resistance to atmospheric corrosion:

NF A 35-502	E24W Qualité 2 à 4, E36W A2-A4
DIN	WT St37-2, WT St37-3, WT St52
Marques commerciales	CORTEN A, B, C – PATINAX – INDATEN – ACOR...

PROCEDURE

Redrying: 662°F (350°C) /1h.

MECHANICAL PROPERTIES

Tensile strength: > 79 770 psi (> 550 MPa)
 Yield strength: > 66 717 psi (> 460 MPa)
 Elongation: > 19 %
 Impact (Charpy V): > 60 J at - 4°F (-20°C)

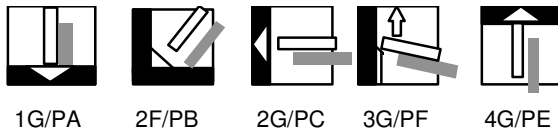
TYPICAL WELD METAL COMPOSITION (%)

C	Mn	Si	Cr	Ni	Cu	P	S
<0.10	1.0	0.4	0.5	0.5	0.4	< 0.025	< 0.025

WELDING PARAMETERS

Diameter: 4.0 mm (5/32") 3.2 mm (1/8") 2.5 mm (3/32")
 Amperage: 150 A 115 A 80 A

WELDING POSITIONS



Rev.: 15_03

Specialized welding alloys and technology. For technical assistance or for ordering: