

❖ Product Description

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| I. Copper coated low alloy solid wire | IV. The weld metal has good mechanical properties |
| II. Uniform copper coating | V. Radiographic weld quality |
| III. Smooth wire feeding and arc stability | |

❖ Range of Application

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| I. Welding of steel pipes, plates and castings | III. Suitable for joining dissimilar combinations of Cr-Mo and Carbon steels |
| II. For high temperatures in refineries, petrochemical and fertilizer plant | |

❖ Classification

- AWS/SFA 5.28 ER70S- B2L

❖ % Chemical Composition

Type of Wire		C	Mn	S	Si	P	Mo	Cr	Ni	Cu	Other Elements
ER70S-B2L	Min	-	0.40	-	0.40	-	0.40	1.20	-	-	-
	Max	0.05	0.70	0.025	0.70	0.025	0.65	1.50	0.20	0.35	0.50

❖ Mechanical Properties of all weld metal

Condition	UTS, Mpa (Min)	YS, Mpa (Min)	% Elongation	Charphy "v" Notch Impact @ 0°C
PWHT	515	400	19	-

❖ Wire Size & Welding Position

- Diameter in mm- 0.60, 0.80, 0.90, 1.00, 1.20, 1.40, 1.60
- Weld Position- All position

❖ Current & Gas Flow

- DCEP; 15-22lit/min

❖ Packaging

Sizes Available in mm	0.60, 0.80, 0.90, 1.00, 1.20, 1.40, 1.60								
Packing Code	A	B	C	D	E	F	G	H	I
Packing Available	SD 100	SD200	SD270	SD 270	SD300	SD300	100kg Drum Pack	250kg Drum Pack	350kg Drum Pack
Net Weight of Wire	1KG	2KG	12.5KG	15KG	12.5KG	15KG	100KG	250KG	350KG

Special Notes: -

- All the value above mentioned are typical values.
- Usually all chemistry and mechanical properties will depend on actual wire chemistry and arc voltage used for welding.

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