

❖ 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. High strength and toughness after PWHT |
| III. Smooth wire feeding and arc stability | VI. Radiographic weld quality |

❖ Range of Application

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| I. Welding of Cr-Mo type creep resistant steels | IV. Cr-Mo and Cr-Mo-V bearing steels having high temperature |
| II. For in refineries, petrochemical and fertilizer plant | |
| III. Joining of P5A materials | |

❖ Classification

- AWS/SFA 5.28 ER80S- B3L

❖ % Chemical Composition

Type of Wire		C	Mn	S	Si	P	Mo	Cr	Ni	Cu	Other Elements
ER80S-B3L	Min	-	0.40	-	0.40	-	0.90	2.30	-	-	-
	Max	0.05	0.70	0.025	0.70	0.025	1.20	2.70	0.20	0.35	0.50

❖ Mechanical Properties of all weld metal

Condition	UTS, MPa (Min)	YS, Mpa (Min)	% Elongation	Charpy "v" Notch Impact @ 0°C
PWHT	550	470	17	-

❖ 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: -

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

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