

❖ Product Description

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| I. Low alloy Chromium Molybdenum Wire designed for high strength | III. Smooth wire feeding |
| II. Exhibits greater resistance to cracking | IV. Excellent strength of welds |
| | V. The weld beads are uniform |

❖ Range of Application:

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| I. Suitable to weld ½Cr- ½Mo, 1Cr-½Mo, 1¼Cr-½Mo steels for high temperatures and corrosive service | II. Extremely suitable for welding heat exchangers, boilers, piping and pressure vessels at service temperatures up to 1000°F |
| | III. More suitable for welds left in as weld condition |

❖ Classification:

- AWS/SFA 5.28 ER70S- B2L

❖ Chemical Composition

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

❖ Mechanical Properties of all weld metal

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

❖ Wire Size & Weld Position

- Diameter in mm-1.6, 2.0 2.40,3.20,4.00 and 5.00
- All position

❖ Current and Gas- Flow Rate

- DCEN & 8-15 lit/min

❖ Packaging

Sizes available in cut length of 1000mm	1.60,2.00,2.40,3.20,4.00,5.00			
Packing Code	A		B	
Packing Available	5kg PLASTIC TUBE	20KG BOX	10KG PAPER TUBE	20KG BOX
Net Weight of Wire	5	20	10	20

Special Note: -

All the value above mentioned are typical values.

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- Usually all chemistry and mechanical properties will depend on actual wire chemistry and arc voltage used for welding.

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