

❖ Product Description

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| <ul style="list-style-type: none"> I. Copper coated wire with 2.20% Cr and 1% Mo content, with low carbon concentration II. Provides high strength welding | <ul style="list-style-type: none"> III. Smooth wire feeding IV. Excellent strength welds produced V. The weld beads are uniform |
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❖ Range of Application:

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| <ul style="list-style-type: none"> I. Suitable to weld 2¼Cr-Mo steels for high temperatures and high pressure vessels II. Exhibits greater resistance to cracking | <ul style="list-style-type: none"> III. Can be used for welding boilers, heat exchangers, piping and pressure vessels where good weld strength is mandatory IV. Also suitable in petro chemical industry for facing on casting and repairs of castings itself |
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❖ Classification:

- AWS/SFA 5.28 ER80- B3L

❖ Chemical Composition

Type of Wire		C	Mn	Si	S	P	Cu	Ni	Cr	Mo	Other Elements Total
ER80- B3L	Min	-	0.70	0.40	-	-	-	-	2.30	0.90	-
	Max	0.05	0.40	0.70	0.025	0.025	0.35	0.20	2.70	1.20	0.50

❖ Mechanical Properties of all weld metal

Condition	UTS, MPa (Min)	YS, MPa (Min)	% Elongation	Charpy “v” Notch Impact @ 0°C
As Welded	550	470	17	-

❖ 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.

- (1) All the value above mentioned are typical values

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Dharwad Works:- Plot no.577 C & D,Belur Industrial Area,Dharwad-580011 (KARNATAKA) INDIA

Vadodara Works:- 67-A,G.I.D.C,Majusar,Savli,Vadodara-397115 (GUJARAT) INDIA

FABTIG 80S B3L



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



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