

# GETIG 308L

## IDENTIFICATION: ER 308L

**SPECIFICATIONS:** AWS /SFA 5.9: ER 308L; DIN 8556-86 WSGX2 CrNi199; BS 2901-90 308S92

**CHARACTERISTICS:** Extra low carbon Austenitic Stainless Steel Filler Rod.

### CHARACTERISTICS:

An extra low carbon 20/10 filler rod which has excellent resistance to intergranular corrosion due to its extra low carbon content. The weld deposit is corrosion and scale resistant and free from porosity. The deposited weld metal meets X-ray/ radiographic quality. Good resistance to oxidizing acids and reducing adds.

### COMPOSITION OF THE WIRE (RANGE) %

C	Mn	Si	S	P
0.025 max	1.0-2.5	0.30-0.65	0.020 max	0.030 max
Cr	Cu	Mo	Ni	
19.5-22	0.50 max	0.5 max	9.0-11.0	

### APPLICATIONS:

- For welding of 19/10 austenitic stainless steel plates of the type AISI 301, 302, 304, 304L, sheets, pipes and tubes used in chemical plants, fertilizer plants, oil refineries, food and dairy industries.
- Can be used for welding stabilized stainless steel 347 & 321 provided service temperatures for structural application are below 400°C.
- Also used for making furniture, hospital and kitchen equipments etc.

### ALL WELDMECHANICAL PROPERTIES

UTS (MPa)	YS (MPa)	ELN (%) (L=4D)	CVN impact strength	
			Temp	Joules
520 min	430 min	35 min	20°C	80-140
			-196°C	30-60

**SHIELDING GAS:** GAS Argon, 99.99%, 6-12 l/min

**Packing Specifications:** Supplied in cut lengths of 1 meter packed in 5 kgs cartons)

### RECOMMENDED CURRENT AND PACKING DATA:

SIZE (MM)	RECOMMENDED CURRENT (AMPS) DC (-)	LENGTH (MM)	KG/PKT (KG)
1.6	100-200	1000	5.00
2.0	150-250	1000	5.00
2.5	200-300	1000	5.00
3.20	300-400	1000	5.00

**Manufactured by: GEE LIMITED**

Regd. Off & Works: plot No.B - 12, MIDC, Kalyan-Bhiwandi Road, Saravli, Kalyan (West) Thane, Maharastra, India.  
Website: www.geelimited.com

**Authorised Distributor: CROSS MARKETING**

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# GRIDUCT B3L

## IDENTIFICATION: GRIDUCT B3L E8018 B3L

**CLASSIFICATION:** AWS/SFA 5.5: E 8018 B3L, BS 2493:2Cr MoLBH, DIN 8575-84 ECrMo2B26

### CHARACTERISTICS:

A basic coated low hydrogen electrode which deposits extra low carbon 2.25Cr%/1.0Mo% weld metal. It is intended for welding creep resisting steels of similar composition, used in power generating plant operating at temperatures upto 6000C. The welds are of X-ray quality.

### WELD METAL ANALYSIS (RANGE) %

C	Mn	S	P
0.05 max	0.5- 0.9	0.025 max	0.03 max
Cr	Mo	Si	
2.0- 2.50	0.90- 1.20	0.2- 0.6	

### TYPICAL APPLICATIONS

ASTM A 335 grade P22 ASTM A199,A200 T3b,T4,T21, T22,A213 T22,A181 F22, boilers, pressure vessels, headers, high pressure piping, heat exchangers and condensers, power generation, oil refineries, petrochemical industries, valve bodies, super heaters hydrocrackers, coal liquefaction plant.

### MECHANICAL PROPERTIES OF THE WELD METAL AFTER PWHT 690°C/1 HR

UTS (MPa)	YS (MPa)	ELN (%) (L=4D)	CVN Impact Strength	
			Temp 0°C	Joules 30-90
550-650	460-580	17-25		

### WELDING PROCEDURE:

Use short arc length. Weaving of electrodes, if necessary should be done at slow speed and keeping a short arc. The electrodes should be used in perfectly dried condition.

**ASMEQUALIFICATION:** QW-432 F.NO4, QW-442 A NO.4

**RECOMMENDED REDRYING:** 3000C/2 hrs, 5 times, total 10 hrs max.

**DIFFUSIBLE HYDROGEN CONTENT IN THE WELD METAL:** Max 5 ml/100g.of weld metal

**MICROSTRUCTURE:** After PWHT, the microstructure consists of tempered bainite.

### RECOMMENDED CURRENT AND PACKING DATA:

Size (mm)	Length mm	AMPS AC (70V) DC (+)	Packing/box (PCS)	WEIGHT/1000Pcs (KG)
2.5	350	60-80	160x4=640	18.9
3.15/3.20	450	90-130	110x4=440	41.6
4.0	450	140-190	70x4=280	67.2
5.0	450	190-250	45x4=180	100.0

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