

GETIG 80SB3L

SPECIFICATIONS: AWS/SFA 5.28-96: ER 80S-B3L

CHARACTERISTICS:

Extra low carbon copper coated 2.4% Cr / 1.0 % Mo alloyed solid wire for TIG welding creep resisting steels of similar composition, used in steam generation plant operating at temperature upto 600°C. Suitable for use in the chemical and petrochemical industries where resistance to hydrogen attack, corrosion from sulphur bearing crude oil and stress corrosion cracking in sour environments is required.

APPLICATIONS:

- ASTM A 387 grade, Cast A 217 WC7
- A199, A200, A213, Grades T22, T36, T4
- A335 grade P22.

SHIELDING GAS: Pure Argon 99.99% 7-10 l/min.

WELDING CURRENT: DC (-)

COMPOSITION OF THE WIRE (RANGE)

C	Mn	Si	Cr	Cu
0.05 max	0.40- 0.70	0.40- 0.70	2.30- 2.70	0.35 max
Ni	Mo	S	P	
0.20 max	0.9- 1.20	0.025 max	0.025 max	

MECHANICAL PROPERTIES OF THE WELD METAL (RANGE) PWHT (690°C/1 hr)

UTS (MPa)	YS (MPa)	ELN (%) (L=4D)
600-720	550-630	18-25

RECOMMENDED CURRENT AND PACKING DATA:

SIZE (mm)	LENGTH (mm)	PACKING/BOX
1.6	1000	5 Kg
2.0	1000	5 Kg
2.4 / 2.5	1000	5 Kg
3.15 / 3.2	1000	5 Kg

Manufactured by: GEE LIMITED

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

Authorised Distributor: CROSS MARKETING

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GETIG 70S2

IDENTIFICATION :ER 70S-2

CLASSIFICATION: AWS A-5.18: ER 70S-2, BS EN ISO 636:2017

DESCRIPTION:

Copper coated filler wire has Al, Ti and Zr as strong deoxidants with Mn and Si content. The wire has very low impurities such as S, P etc and is suitable for applications involving subzero temperatures up to -30°C. This has advantages of semi-killed steels or rusty and contaminated joint area. Smooth flow and gives shiny bead under optimum welding conditions. The deposited weld meet x-ray/radiographic quality code requirement.

TYPICAL USES:

- For welding of structural, pressure vessels and boilers involving unalloyed and micro alloyed structural steel with specified tensile strength upto 550N/mm to meet subzero Impact requirements down to -30°C.
- ASTM A 36, A106 A/B/C, A139 etc
- A516 Grade 70 etc.

SHIELDING GAS: Pure Argon

Welding Current: DC (-)

PACKING DATA:

SIZE (mm)	LENGTH (mm)	PACKING/BOX (KG)
1.6	1000	5 x 4 = 20 Kg
2.00	1000	5 x 4 = 20 Kg
2.40/2.50	1000	5 x 4 = 20 Kg
3.15/3.20	1000	5 x 4 = 20 Kg

Note:

Length / Diameter can be given as per the party's requirement Chemical Analysis and Mechanical Properties of Wire.

COMPOSITION OF THE WIRE (RANGE) %

C	Mn	Si	Zr
0.07 max	0.9-1.4	0.40-0.70	0.02-0.12
Al	Ti	S	P
0.05-0.15	0.05-0.15	0.020 max	0.025 max

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	YS (Pa)	ELN (%) (L=4D)	CVN Impact Strength	
			Temp	Joules
510-620	410-550	22-28	-30°C	30-90

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