

ER 70S-B2L Tig

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|----------------|---|-----------------------|
| CATEGORY | GMAW-GTAW Solid wires | |
| TYPE | Low alloyed welding wire for high tensile strength and creep resistant steels | |
| APPLICATIONS | ER70S-B2L is a low carbon content variation of the ER80S-B2 and is designed for the welding of 1¼Cr½ Mo steel that require a lower as-welded hardness | |
| PROPERTIES | This low carbon version of the B2 type is preferred where as welded repairs are done or where PWHT is not viable | |
| CLASSIFICATION | AWS | A 5.28: ER 70S-B2L |
| | EN ISO | 21952-B: W 52 M CML 1 |

SUITABLE FOR 1¼Cr½ Mo steel, mountainbikes, car frames, stock cars, creep resistant steels.

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS % (TYPICAL)

| C | Mn | Si | Cr | Cu | Mo |
|------|------|------|------|------|------|
| 0.04 | 0.55 | 0.48 | 1.35 | 0.15 | 0.55 |

MECHANICAL PROPERTIES

| Heat Treatment | R _{p0,2} (N/mm ²) | R _m (N/mm ²) | 4d/5d (%) | Impact Energy (J) ISO-V | | | Hardness HRc |
|----------------|---|--|--------------|-------------------------|-------|-------|-----------------|
| | | | | 20°C | -40°C | -60°C | |
| as welded | >489 | >585 | 19 | | | | ~23 |
| PWHT 1hr/620°C | >399 | >517 | 21 | | | | <20 |

Preheat 150°C / Interpass temp. 400°C. max.

WELDING PARAMETERS / PACKING

| D (mm) | Welding Parameters | | Packing (kg) | |
|------------|--------------------|--|--------------|--------|
| | Current (A) (DC-) | | single | master |
| 1.6 x 1000 | 50-120 | | 5 | 25 |
| 2.4 x 1000 | 120-200 | | 5 | 25 |

REDRYING TEMPERATURE not required

GAS ACC. EN ISO 14175: I1