CEWELD ER 70S-B2L Tig

certilas® THE FILLER METAL SPECIALIST

TYPE	Low alloyed welding rod for high tensile strength and creep resistant steels. (1¼Cr/½ Mo, B2L Type)
APPLICATIONS	CEWELD® ER 70S-B2L Tig is a low carbon variant of the ER80S-B2 and was developed for welding 1¼Cr/½ Mo steel, which requires a lower hardness in the welded condition. Typical applications can be found in power plant construction, pressure pipe, turbine and boiler construction as well as mountain bikes, vehicle frames, stock cars and creep-resistant steels.
PROPERTIES	CEWELD® ER 70S-B2L TIg is identical to ER80S-B2, with the exception of the reduced carbon content. This results in lower hardness and strength values, which reduces the tendency to crack, especially if the weld seams are not heat-treated. These steels are usually used for operating temperatures up to 550°C. The low proportion of accompanying elements (Sn, As, Sb, P) in the wire ensures a low Bruscato factor (X < 10 ppm) and therefore insensitivity to temper embrittlement.

CLASSIFICATION

AWS	A 5.28: ER 70S-B2L
EN ISO	21952-B: W 1CML
F-nr	6
FM	3

SUITABLE FOR

For similar 1.25%Cr-0.5%Mo-alloyed, heat-resistant, ferritic steels.
1.7335, 1.7242, 1.7337, 1.7357
13CrMo 4-5, 13CrMo 4-4, 16 CrMo4, 16CrMo 4-4, GS-17CrMo 5-5, G17CrMo5-5
ASTM: A182 grades F11/F12, A199/A200 T11, A217 grades,WC6/WC11, A234 grades WP11/WP12, A335 grades P11/P12, A387 grades 11/12
BSI/AFNOR: K12073, K11598, K 11568, J 12073, J 12072, J 11872, K11564

APPROVALS

CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	P	S	Cr	Mo
0.04	0.45	0.55	0.015	0.015	1.3	0.6

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Hardness
620°C±15°C 1h	420	550	20	HRc

REDRYING

Not required

GAS ACC. EN ISO 14175

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ER 70S-B2L TIG 1,6MM

Packaging	KG/unit	EanCode
Tube	5	8720663417473

ER 70S-B2L TIG 2,4 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663417503