

GETIG 80SB3L

IDENTIFICATION

Getig 80SB3L, ER 80SB3L

CLASSIFICATION

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

DESCRIPTION

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.

CHEMICAL ANALYSIS (RANGE) %

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

MECHANICAL PROPERTIES (RANGE) PWHT (6900C ± 15°C/1 HR)

TS (N/mm ²)	YS (N/mm ²)	EL (%) (L=4D)
600 - 720	550 - 630	18 - 25

TYPICAL 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 (-)

PACKING PARAMETERS

Size (mm)	Length (mm)	Packing / Pkt (kg)	Packing / Box (kg)
1.6	1000	5	5 X 4 = 20
2	1000	5	5 X 4 = 20
2.40 / 2.50	1000	5	5 X 4 = 20
3.15 / 3.20	1000	5	5 X 4 = 20