

TIGFIL 70S-B2L / AUTOMIG 70S-B2L

Classification

AWS A/SFA 5.28 : ER 70S-B2L

Characteristic

This filler metal with low carbon content which reduces hardness and under some condition improves corrosion resistance. The alloy has good resistance to cracking and suitable for weld to be left in as welded condition or when the post weld heat treatment is not accurate.

Typical Application

This wire is suitable for the welding of $1\frac{1}{4}\text{Cr}/\frac{1}{2}\text{Mo}$ steel that require a lower as-welded hardness. Other applications include framework on transportation equipment e.g. auto frames, mountain bikes, etc. Structural supports and ductwork which are used for higher temperature service than mild steels.

Wire Chemistry

| C | S | P | Mn | Si | Cr | Ni | Mo | Cu |
|----------|-----------|-----------|-----------|-----------|-----------|----------|-----------|----------|
| 0.05 max | 0.025 max | 0.025 max | 0.40-0.70 | 0.40-0.70 | 1.20-1.50 | 0.20 max | 0.40-0.65 | 0.35 max |

Properties of weld metal with 100% Argon Ar/1-5%O₂ gas shielding Current Condition: TIG : DC (-) MIG : DC (+)

All Weld Mechanical Properties As welded condition

| Shielding Gas | UTS | YS | Elongation | CVN Impact, value J | Hardness (BHN) |
|---------------|---------|---------|-------------|---------------------|-------------------|
| | MPa | MPa | % (=4×d) L | at - 30°C | 200 max (approx.) |
| 100% Ar | 400 min | 515 min | 19min | 28 min | |

The chemistry and mechanical properties of the weld metal will vary with the type of shielding gas used.

All Weld Mechanical Properties PWHT : 620±15°C/2hrs.

Packing Specifications

Supplied in D 300 plastic spools - layer wound / Weight - 15 Kg

Each plastic spool is sealed in a polyethylene bag and then packed in a corrugated box which is shrink-wrapped.

Packing Data for TIGFIL 70S-B2L

| | 1.6 | 2.0 | 2.5 | 3.2 | 4.0 |
|-----------------------------|------|------|------|------|------|
| Dia., mm | | | | | |
| Length,mm | 1000 | 1000 | 1000 | 1000 | 1000 |
| Net wt per tube,kg | 5 | 5 | 5 | 5 | 5 |
| No of Plastic Tubes per Box | 4 | 4 | 4 | 4 | 4 |
| Net wt,Box,kg | 20 | 20 | 20 | 20 | 20 |

TIGFIL Wires are sealed in polyethylene bags and then packed in primary tubes.

TIGFIL Wires are also available in 5 Kg PSLW spools in 0.8, 1.0 and 1.2 mm sizes for orbital GTAW/TIG welding.

AUTOMIG 70S-B2L, in spool form, available for GMAW process, on demand.



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