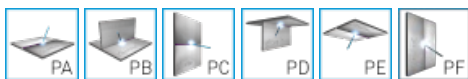


CEWELD ER 70S-B2L

TYPE	Low alloyed welding wire for high tensile strength and creep resistant steels. (1¼Cr/½ Mo, B2L Type)						
APPLICATIONS	CEWELD® ER 70S-B2L 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 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: G 1CML					
	F-nr	6					
	FM	5					
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 WELD 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)	R _m (MPa)	A5 (%)	Hardness
	620°C±15°C 1h			420	570	20	HRc
REDRYING	Not required						
GAS ACC. EN ISO 14175	M21						