

# CEWELD ER 70S-B2L Tig

**TYPE** Low alloyed welding rod for high tensile strength and creep resistant steels. (1 ¼Cr/½ Mo, B2L Type)

**APPLICATIONS** CEWELD® ER 70S-B2L Tig is a low carbon variant of the ER80S-B2 and was developed for welding 1 ¼Cr/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 (%)**

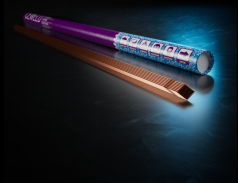
| C    | Si   | Mn   | P     | S     | Cr  | Mo  |
|------|------|------|-------|-------|-----|-----|
| 0.04 | 0.45 | 0.55 | 0.015 | 0.015 | 1.3 | 0.6 |

**MECHANICAL PROPERTIES**

| Heat Treatment | R <sub>P0.2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Hardness |
|----------------|-------------------------|----------------------|--------------------|----------|
| 620°C±15°C 1h  | 420                     | 550                  | 20                 | HRc      |

**REDRYING** Not required

**GAS ACC. EN ISO 14175** I1



# CEWELD ER 70S-B2L Tig

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 |