

TALARC B3L TIG

CLASSIFICATION

AWS SPECIFICATION	EN SPECIFICATION
AWS A5.28: ER80S-B3L	EN ISO 21952-B: W2C1ML

ALLOY TYPE

2.25Cr-1Mo alloyed steel TIG rod to be used for the welding of creep resistant steel.

APPLICATIONS

Low alloy copper-coated TIG rod with 2.25% Cr and 1%Mo content, with low carbon (<0.05%) to be used for the welding of creep resistant steel. Chemical composition of rod conforming to AWS specification. It is used in chemical industry and in the ammonia synthesis process, for heat exchangers, boilers, piping and pressure vessels for temperature service up to about 600°C. It will also find applications in the petro-chemical industries, suitable for facing on casting and for casting repairs.

TYPICAL CHEMICAL COMPOSITION OF WIRE

C%	Mn%	Si%	S%	P%	Cr%	Ni%	Mo%	Cu%
0.03	0.60	0.60	0.010	0.010	2.50	-	1.0	0.15

TYPICAL MECHANICAL PROPERTIES

GAS		Yield strength	Tensile strength	Elongation	Impact energy (Charpy V)				
		Rs	Rm	On % 5d	+ 20°C	0°C	-20°C	-40°C	-60°C
		(MPa)	(MPa)	%	(Joule)	(Joule)	(Joule)	(Joule)	(Joule)
Argon	After PWHT	510	600	22	210	-	-	-	-

WELDING GUIDELINES

Preheat and inter-pass temperature 200°C. PWHT at 690°C for an hour.

TECHNICAL INFORMATION

Gas: Argon 100% (EN ISO14175)

Welding positions: all positions



WELDING PARAMETERS and PACKAGING DATA

Diameter(mm)	2.4
Length(mm)	1000
Carton	5Kg
Current	DC-Straight (-) polarity

Diam.	5kg Tube
2.4mm	INTB3L24

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