

## DESCRIPTION

Executive 70S-B2L is designed to weld 1-1/4Cr – ½ Mo steels using MIG or TIG welding processes where high temperature service and creep resistance is important. Executive 70S-B2L is a low carbon version of Executive 80S-B2 and is utilized for welding creep resistant steels where a lower as welded hardness is required or where the weldment may not be subject to PWHT.

Executive 70S-B2L filler metal is produced using high quality raw materials and tightly controlled chemistry to provide top quality, exceptionally clean wires that deliver smooth feedability and the results fabricators demand.

## APPLICATIONS & FEATURES

Executive 70S-B2L is used to weld creep resistant steels such as structural supports and ductwork which are subject to elevated temperature service and part that may not be subject to PWHT. It is also suitable for casting repairs.

Typical material grades include ASTM A387-Gr 11/12, A335-Gr 11/12, A213 Gr-11/12 and F182-Gr 11/12.

## TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Mn	Sn	Si	Nb	Cr	As	Mo	P	S	Cu	Sb	Ni	V	Ti	Al
0.05	0.54	0.008	0.44	0.001	1.26	0.0009	0.41	0.007	0.011	0.15	0.0033	0.09	0.006	0.001	0.005

**Tensile Strength:** 75,000 PSI min      **Yield Strength:** 58,000 PSI min      **Elongation:** 19%  
**Charpy V-Notch:**

## TYPICAL WELDING PARAMETERS

Process	Diameter	Voltage	Amperage	Speed (in/min)	Shielding Gas / Flux	
GMAW - Short	.035"	14-20	90-160	100	100% CO <sub>2</sub>	
	.045"	16-20	120-200	150	75% Ar / 25% CO <sub>2</sub>	
	- Spray	.035"	25-28	180-230	125	98% Ar / 2% O <sub>2</sub>
	.045"	25-30	250-350	150	75% Ar / 25% CO <sub>2</sub>	
GTAW	.093"	Direct Current; Electrode -			100% Ar	
	.125"					

## STANDARD PACKAGING

<b>GMAW</b> (MIG)	33-lb plastic spools	1,980-lb pallet
<b>GTAW</b> (TIG)	10-lb plastic tube	40-lb box

## CLASSIFICATION

AWS/SFA 5.28, Class **ER70S -B2L**

