

## F Cr-Mo 1L

**CODIFICATION:**                      **AWS :**    SFA 5.28 ER70S-B2L

### **CHARACTERISTICS AND APPLICATIONS:**

F Cr-Mo 1L is a copper-coated solid wire for GTAW, available in bright finish, gives smooth flow, stable arc and spatter free under optimum welding conditions. It gives radiographic quality welds. It is suitable for welding low carbon 1.25Cr - 0.5Mo steel. The weld metal possesses good high temperature properties. It deposits notch free weld deposit with excellent mechanical properties. Especially suitable for welding of pipes & tubes of matching composition in Power plants, Refineries, Petrochemicals, Fertilizer plants, etc. Suitable for welding of ASTM steels: Grade F2, F11, F12 class 1 & 2 of SA-182, Grade T11 of SA-199, Grade T2, T11 & T12 of SA-213, Grade WC6 of SA-217, Grade P2, P11 & P12 of SA-335, Grade FP2, FP11 & FP12 of SA-369, Grade 2, 11 & 12 of SA-387, Grade CP2, CP11 & CP12 of SA-426, etc.

### **TYPICAL CHEMICAL COMPOSITION OF SOLID WIRE:**

Element	C	Mn	Si	S	P	Cr	Mo	Cu
%	0.04	0.50	0.55	0.010	0.012	1.30	0.55	0.10

### **TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:**

**(PWHT: 620°C FOR 1 HR)**

UTS	YS	Elongation
(MPa)	(MPa)	(L = 4d) %
530	450	21

**SHIELDING GAS:** Argon

**CURRENT CONDITION:** DCEN

**WELDING POSITION:** H, F, VU, OH

### **PACKING:**

**STANDARD SIZE**                      Diameter 1.6 mm, 2.0 mm, 2.4 mm & 3.2 mm in cut lengths of 500 mm / 1000 mm each.

**QUANTITY**                              5 kg wire put in an air-tight polythene bag and finally packed in a plastic container.  
 Identification    AWS code is punched on each wire.