

HEAT RESISTING STEEL

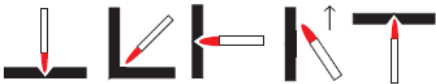
GLST-88B2 ELECTRODE

Classification: AWS A5.5M E5518-B2
EN E Cr Mo1 B 42

Characteristics and Application:

GLST-88B2 is an iron powder and low hydrogen type stick electrode for all-position welding, in which weld metal chemical composition is 1.25%Cr-0.5%Mo. Its weldability is featured by stable arc, less spatter, smooth bead appearance, and easy slag detachability and excellent radiographic test result. It is applicable in heating surface tube of boiler, piping steels and heat exchanger tubes under 550°C .

Welding Position :



Chemical Composition of Deposited Metal :

Element wt%	C	Mn	Si	Cr	Mo	P	S
AWS	0.05-0.12	0.90	0.80	1.00-1.50	0.40-0.65	0.03	0.03
Type Value	0.075	0.75	0.46	1.29	0.56	0.013	0.009

Mechanical Property of Deposited Metal:

	Yield Stress MPa	Tensile Strength MPa	Elongation %	Charpy V-notch J/°C	PWHT
AWS	460	550	19	27/20	690°C±15°C/1hr
Type Value	520	630	28	120/20	690°C±15°C/1hr

Notes on Usage:

- 1 Dry the stick electrodes at 350-400°C for one hour before welding.
- 2 Preheating and interpass temperature at 160-220°C and try to keep interpass temperature.
- 3 Keep short arc length when welding.To avoid blowholes when striking the arc, please use backstep method welding technique during welding process.
- 4 To relieve stress, PWHT at 690°C±15°C.
- 5 Current type:DC or AC
- 6 Keep low hydrogen situation during whole welding proess.
- 7 Because of excessive heat input, the impact value tends to be lower. Therefore, choose proper heat input is very important.

Sizes and Recommended Parameters:

Diameter and Size/mm		2.6×350	3.2×350	4.0×400	5.0×450
Current/Amp	F	55-85	90-130	140-190	170-220
	V, OH	50-80	80-120	120-160	-