

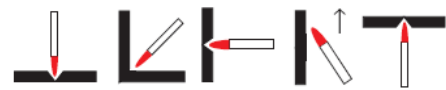
HEAT RESISTING STEEL
GLST-88B8 ELECTRODE

Classification: AWS A5.5 E8018-B8
AWS A5.5M E5518-B8
EN E Cr Mo9 B 42 H5

Characteristics and Application:

GLST-88B8 is an iron powder and low hydrogen type stick electrode for all-position welding, in which weld metal chemical composition is 9%Cr-1%Mo. It is applicable in tuber service at 600°C, such as Cr9Mo, A213-T9, A335-P9.

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	0.055	0.72	0.39	8.54	0.92	0.016	0.012

Mechanical Property of Deposited Metal:

	Yield Stress MPa	Tensile Strength MPa	Elongation %	Charpy V-notch J/°C	PWHT
AWS	460	550	19	-	740°C ±15°C/1hr
Type Value	540	640	28	-	740°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 205-260°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 740°C±15°C.
- 5 Current type:DC or AC
- 6 Keep low hydrogen situation during whole welding proess.

Sizes and Recommended Parameters:

Diameter and Size/mm		2.6×350	3.2×350	4.0×400	5.0×450
Current/Amp	F	70-120	90-130	140-1890	170-220
	V, OH	60-100	80-120	120-160	-