

HEAT RESISTING STEEL

GLST-98B3 ELECTRODE

Classification: AWS A5.5M E6218-B3

EN E Cr Mo 2 B 42

Characteristics and Application:

GLST-98B3 is an iron powder and low hydrogen type stick electrode for all-position welding, in which weld metal chemical composition is 2.25%Cr-1%Mo. It has excellent weldability: stable arc, less spatter, smooth bead appearance, and easy slag detachability and excellent radiographic test result. It provide reliable creep rupture properties for high temperature service at 550 °C. It is suitable for pipes under high temperature and high pressure, compound chemical machinery and etc at 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	2.00-2.50	0.90-1.20	0.03	0.03
Type Value	0.08	0.65	0.63	2.31	1.05	0.015	0.010

Mechanical Property of Deposited Metal:

	Yield Stress MPa	Tensile Strength MPa	Elongation %	Charpy V-notch J/°C	PWHT
AWS	530	620	17	27/20	690°C±15°C/1hr
Type Value	620	680	26	140/20	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	140-1890	190-240
	V, OH	50-80	80-120	120-160	-