

# Welding Solutions

## For Thermal Power Plants

### TIG FILLER WIRES

TIG welding still remains as a major welding method in fabrication of boiler, steam and gas turbines, casings, and other components for Thermal power plants. ADOR Provides the best welding solutions by offering a consistent, superior quality filler wires to produce high performing weld joints.

The following Table highlights the various filler wires from ADOR range together with the details of the materials on which they can be used along with the welding procedural details.



ADOR Brand Name & AWS classification	Nominal Chemistry of wire	Base materials usually welded-SA	Usual temperature of operation up to Deg C	Usual Welding procedure requirements	Usual components
TIGFIL70SA1 ER70SA1	0.5Mo	204 Gr A; 217 Gr WCl	550		Pipe to pipe/tee, end cover manifold, drum stub & safety valve, CRH stub & safety valve
TIGFIL 80SG ER80SG	1Cr-0.5Mo	335 Gr.P11,P12	570	Preheat & IPT=200-300° C PWHT=700-720° C for 2 hrs	Piping jobs
TIGFIL 90SG ER90SG	2.25Cr-1Mo	335 Gr P22	600	Preheat & IPT=200-350° C PWHT=700-750° C for 2 hrs	Reactor pressure vessels
TIGFIL 80SB2 ER80SB2	1.25Cr-0.5Mo	335 GrP11,P12	570	Preheat & IPT=200-350° C PWHT=700-750° C for 2 hrs	Pipe to NRV/SH control valve/RH control val
TIGFIL 90SB3 ER90SB3	2.25Cr-1Mo	335 Gr P22	600	Preheat & IPT=200-350° C PWHT=700-750° C for 2 hrs	Pipe to pipe/Bend/Valve/Tee/ Connector/Header nipple
TIGFIL 90SB9 ER90SB9	9Cr-1Mo	387 Gr 91, 335 P91, 213 T91	650	Preheat & IPT 200-370° C PWHT as per spec.	Super heater tubes, re-heater tubes and steam boilers



WELDERS TO THE NATION  
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