



APPENDIX II (Cont'd.)

COL.	GE SPEC	AMS	CLASS	COL.	GE SPEC	AMS	CLASS
AN	B21B123A2 None None	A5.1 A5.28 A5.29	E11018M ER110S-1 E110T5-K4 E111T1-K4	AV AX AY	SEE NOTE 4 SEE NOTE 4 SEE NOTE 1		
AO	SEE NOTE 1						
AP	B21B26 None	A5.4 A5.9	E349-15/16 ER349	AZ	B21B111	AMS	5798 wire
AQ	B50A485 None	AMS AMS	5795BM N-155 electrode 5794A, N-155 wire	BA	B21B63B2 B21B70	AMS	5797 electrode 5796 wire
AR	B21B91A SEE NOTE 2	None	Rexweld VT	BB	None	AMS	5832
AS	B21B35 B21B77 None	A5.4 A5.9 A5.22	E410-15/16 ER410 E410TX-Y	BC BD	B21B88 B21B110 None	A5.11 A5.14 A5.11 A5.14	ENi CrFe-3 ER NiCr-3 E NiCu-2 ER NiCu-7
AT	SEE NOTE 2			BE	B21B30 B21B17	A5.4 A5.9 A5.22	E347-15/16 ER347 E347TX-Y
AU	B21B33 B21B136 None	A5.4 A5.9 A5.22	E309-15/16 ER309 E309TX-Y	BF	B50A783A	None	(Nimonic 263) (wire)
AU-1 Note 5	B21B157 None	A5.4 A5.9	E309L-15/16 ER309L	BG BH	None B50A824	AMS None	5801 (wire) (MM-918)
		A5.22	E309LTX-Y	BI		5.14 AMS	ERNiCrMo-3 5837
				BJ		5.14 AMS	ERNiFeCr-2 5832
				BK	None	A5.28	ER90S-B9
					None	A5.5 A5.5	E9016-B9 E9018-B9
				BL	None	A5.14	ERNiCrMo-1

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APPENDIX II (Cont'd.)

WELD FILLER METALS

NOTES:

- (1) Refer to P8G-AG10
- (2) See Materials & Processes Engineer
- (3) Weldments between 410 and Cr-Mo steels should be limited to applications where the operating temperature is below 950F.
- (4) Refer to P8G-AG6.
- (5) For FCAW electrodes, "X" may be 0 or 1, and "Y" may be 1 or 4 as appropriate for the qualified welding procedure

SPECIAL REQUIREMENTS:

- (A) When notch toughness requirements are specified, the weld filler metals shall be tested and certified to the specified properties.
- (B) Alloys containing more than 10% cobalt can crack when contaminated with copper. This contamination can result from lightly scraping with copper. All copper to be used must be nickel or chromium plated.
- (C) Unless the process is specified on the engineering drawing, Weld Filler Metals in the same Column may be used interchangeably provided that (1) there is a qualified procedure for that class of filler and process, (2) the electrode and process are suitable for use in the intended welding position and within any limitations imposed on joint accessibility by component configuration, and (3) consideration has been given to the advisability of use of low carbon version of electrodes to avoid intergranular carbide precipitation and reduced weld corrosion resistance, or to avoid lower weld creep and rupture strength that may result from use of the low carbon versions. Turbine Materials and Process Engineering should be consulted regarding the details of items (2) and (3).