



CEWELD ER 80S-B2 Tig

TYPE	Copper coated welding wire for welding creep resistant ferritic steels.				
APPLICATIONS	Is a Filler metal for high temperature creep resistant 1.25%Cr 0.5%Mo ferritic steel. These steels are used for creep resisting applications up to ~550 °C. Typical applications in power generation plant include steam piping, turbines and boilers; the alloy also finds applications in the chemical and petro-chemical industries.				
PROPERTIES	The CEWELD® ER 80S-B2 Tig has low levels of tramp elements (e.g. Sn, As, Sb and P) providing a low Bruscato Factor(X< 10 ppm)for temper embrittlement resistant applications.				
CLASSIFICATION	AWS	A 5.28: ER 80S-B2			
	EN ISO	21952-B: W 1CM			
	F-nr	6			
	FM	3			
SUITABLE FOR	For matching 1.25%Cr 0.5%Mo creep resisting ferritic steels. 13CrMo4-5, 16CrMo4-4, GS-17CrMo5-5 ASTM: A182 grades F11/F12, A199/A200 T11, A217 grades WC6/WC11, A234 grades WP11/WP12, A335 grades P11/P12, A387 grades 11/12				
APPROVALS	CE				
WELDING POSITIONS					
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn	Cr	Mo
	0.09	0.6	0.6	1.3	0.5
ALL WELD MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} MPa	R _m MPa	A5 (%)	Impact Energy (J) ISO-V RT
	660°C- 700°C /1h	460	560	20	55
REDRYING TEMPERATURE	Not required				
GAS ACCORDING EN 14175	I1				



CEWELD ER 80S-B2 Tig

ER 80S-B2 TIG 1,6MM

Type	KG/unit	EANCode
Tube	5	8720663417466

ER 80S-B2 TIG 2,0 X
1000MM

Type	KG/unit	EANCode
Tube	5	8720663417480

ER 80S-B2 TIG 2,4 X
1000MM

Type	KG/unit	EANCode
Tube	5	8720663417497

ER 80S-B2 TIG 3,2 X
1000MM

Type	KG/unit	EANCode
Tube	5	8720663417527