



# CEWELD ER 80S-B2

TYPE	Copper coated welding wire for welding creep resistant ferritic steels.(ER 80S-B2, G 1CM)															
APPLICATIONS	CEWELD® ER 80S-B2 is a Filler metal for high temperature creep resistant 1.25%Cr0.5%Mo ferritic steel. Preferably used for steels 13CrMo4-5 or ASTM A335 P11/P12. CEWELD® ER 80S-B2 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	CEWELD® ER 80S-B2 has low levels of tramp elements (eg. Sn, As, Sb and P) providing a low Bruscato Factor(X< 10 ppm)for temper embrittlement resistant applications.															
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.28: ER 80S-B2</td> </tr> <tr> <td>EN ISO</td> <td>21952-B: G 1CM</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>3</td> </tr> </table>	AWS	A 5.28: ER 80S-B2	EN ISO	21952-B: G 1CM	F-nr	6	FM	3							
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EN ISO	21952-B: G 1CM															
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FM	3															
SUITABLE FOR	<p><b>Typ 1Cr0,5Mo, ISO 15608: ~5,1</b>            1.7205, 1.7218, 1.7225, 1.7228, 1.7254, 1.7258, 1.7262, 1.7335, 1.7337, 1.7350, 1.7354, 1.7357, 1.7728            13CrMoV42, 13CrMo4-4, 13CrMo4-5, 15CrMo3, 15CrMo5, 13CrMoV42, 15Cr3, 16MnCr5, 20MnCr5, 15CrMo5, 24CrMo5, 25CrMo4, GS-22CrMo5, GS-22CrMo54, GS 17CrMo5-5, 16CrMoV4, 42CrMo4, 42CrMo4V, 41CrMo4V,            ASTM A 182 Gr. F11 / F12; A 193 Gr. B7; A 213 Gr. T12; A 217 Gr. WC6; A 234 Gr. WP11; A335 Gr. P11, P12; A 336 Gr. F11, F12; A 426 Gr. CP12 ; A 199; A200; A 387 Gr A11 / 12</p>															
APPROVALS	CE															
WELDING POSITIONS																
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <td style="width: 25%;">C</td> <td style="width: 25%;">Si</td> <td style="width: 25%;">Mn</td> <td style="width: 25%;">Cr</td> <td style="width: 25%;">Mo</td> </tr> <tr> <td>0.09</td> <td>0.6</td> <td>0.6</td> <td>1.3</td> <td>0.5</td> </tr> </table>	C	Si	Mn	Cr	Mo	0.09	0.6	0.6	1.3	0.5					
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ALL WELD MECHANICAL PROPERTIES	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <td style="width: 25%;">Heat Treatment</td> <td style="width: 10%;">R<sub>p0,2</sub></td> <td style="width: 10%;">R<sub>m</sub></td> <td style="width: 10%;">A<sub>5</sub></td> <td style="width: 40%;">Impact Energy (J) ISO-V</td> </tr> <tr> <td>660°C- 700°C /1h</td> <td>MPa</td> <td>MPa</td> <td>(%)</td> <td>RT</td> </tr> <tr> <td></td> <td>470</td> <td>560</td> <td>20</td> <td>80</td> </tr> </table>	Heat Treatment	R <sub>p0,2</sub>	R <sub>m</sub>	A <sub>5</sub>	Impact Energy (J) ISO-V	660°C- 700°C /1h	MPa	MPa	(%)	RT		470	560	20	80
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660°C- 700°C /1h	MPa	MPa	(%)	RT												
	470	560	20	80												
REDRYING TEMPERATURE	Not required															
GAS ACCORDING EN 14175	M21															



# CEWELD ER 80S-B2

ER 80S-B2 0,8MM

Type	KG/unit	EANCode
BS-300	15	8720663424327

ER 80S-B2 1,0MM

Type	KG/unit	EANCode
BS-300	15	8720663417442

ER 80S-B2 1,2MM

Type	KG/unit	EANCode
BS-300	15	8720663417459