



CEWELD ER 80S-B2

TYPE	Copper coated welding wire for welding creep resistant ferritic steels.													
APPLICATIONS	Filler metal for high temperature creep resistant 1.25%Cr0.5%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 filler metal has low levels of tramp elements (eg. Sn, As, Sb and P) providing a low Bruscatto Factor(X< 10 ppm)for temper embrittlement resistant applications.													
CLASSIFICATION	<table><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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SUITABLE FOR	For matching 1.25%Cr0.5%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 0.09	Si 0.6	Mn 0.6	Cr 1.3	Mo 0.5									
ALL WELD MECHANICAL PROPERTIES	Heat Treatment 660°C- 700°C /1h	R _{P0,2} MPa 470	Rm MPa 560	A5 (%) 20	Impact Energy (J) ISO-V RT 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