CEWELD ER 80S-B8

certilas® THE FILLER METAL SPECIALIST

TYPE

Copper-coated medium alloyed welding wire for welding creep and hydrogen pressure resistant steels. 9%Cr-alloyed steels (CrMo9, B8

APPLICATIONS

CEWELD® ER 80S-B8 is a solid wire with 9% Cr and 1% Mo to be used for welding creep resistant steel. It finds applications in power plants, chemical or petro-chemical industry and in the ammonia synthesis process. It is also used for heat exchangers, boilers, piping and pressure vessels for temperature service up to 600°C.

PROPERTIES

CEWELD® ER 80S-B8 is more corrosion resistant than the requirements for 5%Cr-0.5%Mo steels. .

CLASSIFICATION

AWS	A 5.28: ER 80S-B8
EN ISO	21952-A: G CrMo9
F-nr	6
FM	4

SUITABLE FOR

9%Cr-1%Mo
1.7386, 1.7388, 1.7389
BS 3100 Gr B6, BS 3604 Gr CFS 629-470, HFS 629-470, BS 3604 Gr HFS 629-590, CFS 629-590, GS-12CrCrMo 10-1, X12CrMo 9-1, X7CrMo 9-1
ASTM: A182 Gr F9, A199 Gr T9 , A213 Gr T9 , A217 Gr C12 , A234 Gr WP9, A335 Gr 9, A336 Gr F9, A387 Gr 9,

APPROVALS

CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	Cr	Mo	Other
0.08	0.41	0.53	9.15	1.05	0.03

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ MPa	Rm MPa	A5 (%)	Impact Energy (J) ISO-V RT
745°C±15°C /1h	490	600	20	110

REDRYING TEMPERATURE

Not required

GAS ACCORDING EN 14175

M21

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ER 80S-B8 1,2MM

Type	KG/unit	EANCode
BS-300	2	8720663416865