



CEWELD ER 80S-B2 Tig

TYPE Copper coated welding wire for welding creep resistant ferritic steels.

ANWENDUNGEN 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.

EIGENSCHAFTEN 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.

KLASSIFIKATION

AWS	A 5.28: ER 80S-B2
EN ISO	21952-B: W 1CM
F-nr	6
FM	3

GEEIGNET FÜR 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

ZULASSUNGEN CE

SCHWEISSPOSITIONEN



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn	Cr	Mo
	0.09	0.6	0.6	1.3	0.5

MECHANISCHE GÜTEWERTE	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V	Hardness
					RT	
	660°C- 700°C 1h	460	560	20	55	HRc

RÜCKTROCKNUNG Not required

GAS ACC. EN ISO 14175 I1



CEWELD ER 80S-B2 Tig

ER 80S-B2 TIG 1,6MM

Packaging	KG/unit	EanCode
Tube	5	8720663417466

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

Packaging	KG/unit	EanCode
Tube	5	8720663417480

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

Packaging	KG/unit	EanCode
Tube	5	8720663417497

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

Packaging	KG/unit	EanCode
Tube	5	8720663417527