

CEWELD ER 80S-B3L

Tig

TYPE Copper coated TIG welding wire for welding creep and hydrogen –resistant steels. (2.25% Cr and 1% Mo, B3L Type)

APPLICATIONS CEWELD® ER 80S-B3L Tig finds applications in the chemical industry, in the ammonia synthesis process, for heat exchangers, boilers, piping, and pressure vessels for temperature service up to about 600°C. It will also find applications in the petro-chemical industries, as it is suitable for facing on castings and for casting repairs.

PROPERTIES CEWELD® ER 80S-B3L Tig is a low alloy copper-coated TIG rod with 2.25% Cr and 1% Mo content, with low carbon content (less than 0.05%), to be used for welding creep resistant steels.

CLASSIFICATION

| | |
|--------|-------------------|
| AWS | A 5.28: ER80S-B3L |
| EN ISO | 21952-B: W 2C1ML |
| F-nr | 6 |
| FM | 3 |

SUITABLE FOR **For 2.5%Cr-1%Mo-alloyed, heat-resistant, ferritic steels of the same type.**
 1.7380, 1.7379
 10CrMo 9-10, G-17CrMo 9-10, GS-18 CrMo 9 10
ASTM: A182 F22, A199/A200 grades T21/T22, A213 T22, A217 WC9, A234 WP22, A335 P22, A387 grades 21/22
AFNOR/BSI: 10CD9-10, SS7380, 10H2M, B.S. grade 45, K21390, K21590, J22091, J21890

APPROVALS CE

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

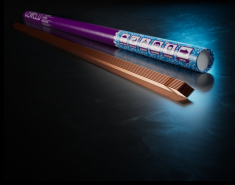
| C | Si | Mn | P | S | Cr | Mo |
|------|-----|-----|------|------|-----|----|
| 0.03 | 0.6 | 0.6 | 0.01 | 0.01 | 2.5 | 1 |

MECHANICAL PROPERTIES

| Heat Treatment | R _{P0,2} (MPa) | R _m (MPa) | A ₅ (%) | Impact Energy (J) ISO-V | | Hardness |
|----------------|-------------------------|----------------------|--------------------|-------------------------|--|----------|
| | | | | RT | | |
| 690°C±15°C 1h | 490 | 560 | 18 | 100 | | HRc |

REDRYING Not required

GAS ACC. EN ISO 14175 I1



CEWELD ER 80S-B3L Tig

ER 80S-B3L TIG 2,4 X
1000MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| Tube | 5 | 8720663417510 |

ER 80S-B3L TIG 3,2 X
1000MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| Tube | 5 | 8720663417534 |