CEWELD ER 80S-B3L

TYPE

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

APPLICATIONS

CEWELD® ER 80S-B3L 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 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: G 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 WELD METAL (%)

C	Si	Mn	P	S	Cr	Mo
0.03	0.6	0.6	0.015	0.015	2.5	1

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Hardness
690°C±15°C 1h	490	560	18	HRc

REDRYING

Not required

GAS ACC. EN ISO 14175

M21