
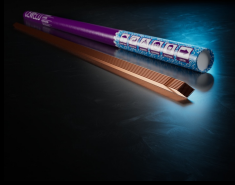


# CEWELD ER 80S-B3L

## Tig

TYPE	Copper coated TIG welding wire for welding creep and hydrogen –resistant steels.																	
TOEPASSINGEN	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.																	
EIGENSCHAPPEN	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.																	
CLASSIFICATIE	AWS	A 5.28: ER80S-B3L																
	EN ISO	21952-B: W 2C1ML																
	F-nr	6																
	FM	3																
GESCHIKT VOOR	<p><b>For 2.5%Cr-1%Mo-alloyed, heat-resistant, ferritic steels of the same type.</b></p> <p>1.7380, 1.7379            10CrMo 9-10, G-17CrMo 9-10, GS-18 CrMo 9 10  <b>ASTM:</b> A182 F22, A199/A200 grades T21/T22, A213 T22, A217 WC9, A234 WP22, A335 P22, A387 grades 21/22  <b>AFNOR/BSI:</b> 10CD9-10, SS7380, 10H2M, B.S. grade 45, K21390, K21590, J22091, J21890</p>																	
GOEDKEURINGEN	CE																	
LASPOSITIES																		
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</th> <th>Cr</th> <th>Mo</th> </tr> </thead> <tbody> <tr> <td>0.03</td> <td>0.6</td> <td>0.6</td> <td>0.01</td> <td>0.01</td> <td>2.5</td> <td>1</td> </tr> </tbody> </table>		C	Si	Mn	P	S	Cr	Mo	0.03	0.6	0.6	0.01	0.01	2.5	1		
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MECHANISCHE WAARDEN	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R<sub>p0,2</sub> (MPa)</th> <th rowspan="2">R<sub>m</sub> (MPa)</th> <th rowspan="2">A<sub>5</sub> (%)</th> <th colspan="2">Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness</th> </tr> <tr> <th colspan="2">RT</th> </tr> </thead> <tbody> <tr> <td>690°C±15°C 1h</td> <td>490</td> <td>560</td> <td>18</td> <td colspan="2">100</td> <td>HRc</td> </tr> </tbody> </table>		Heat Treatment	R <sub>p0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness	RT		690°C±15°C 1h	490	560	18	100		HRc
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			RT															
690°C±15°C 1h	490	560	18	100		HRc												
HERDROGEN	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