



# CEWELD ER 80S-B3L

## Tig

TYPE	Copper coated TIG welding wire for welding creep and hydrogen –resistant steels.																
ANWENDUNGEN	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.																
EIGENSCHAFTEN	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.																
KLASSIFIKATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.28: ER80S-B3L</td> </tr> <tr> <td>EN ISO</td> <td>21952-B: W 2C1ML</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>3</td> </tr> </table>	AWS	A 5.28: ER80S-B3L	EN ISO	21952-B: W 2C1ML	F-nr	6	FM	3								
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GEEIGNET FÜR	<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>																
ZULASSUNGEN	CE																
SCHWEISSPOSITIONEN																	
TYPISCHE CHEMISCHE ANALYSE DES FÜLLMETALLS (%)	<table border="1"> <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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RÜCKTROCKNUNG	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