



# CEWELD ER 80S-B2 Tig

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

**TOEPASSINGEN** 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.

**EIGENSCHAPPEN** 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.

**CLASSIFICATIE**

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

**GESCHIKT VOOR** 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

**GOEDKEURINGEN** CE

**LASPOSITIES**



**TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)**

C	Si	Mn	Cr	Mo
0.09	0.6	0.6	1.3	0.5

**MECHANISCHE WAARDEN**

Heat Treatment	R <sub>P0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness
				RT		
620°C±15°C 1h	560	660	24	200		HRc

**HERDROGEN** 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