



# CEWELD ER 80S-B8 Tig

|                                                      |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                            |                         |           |                         |     |          |      |
|------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------|-------------------------|-----------|-------------------------|-----|----------|------|
| TYPE                                                 | Medium alloyed, high-strength 9% Cromium Alloy.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                            |                         |           |                         |     |          |      |
| APPLICATIONS                                         | Low Alloyed copper-coated solid wire with 9% Cr and 1% Mo to be used for welding creep resistant steel. It finds applications in power plants, chemical or petro-chemical industry and in the ammonia synthesis process. It is also used for heat exchangers, boilers, piping and pressure vessels for temperature service up to 600 °C.                                                                                                                                                                                                                                                      |                            |                         |           |                         |     |          |      |
| PROPRIÉTÉS                                           | Corrosion resistance is higher than 5Cr-0.5Mo steels requirements. To be used with shielding gas Ar+O2.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                            |                         |           |                         |     |          |      |
| CLASSIFICATION                                       | AWS                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | A 5.28: ER 80S-B8          |                         |           |                         |     |          |      |
|                                                      | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | 21952-A: W CrMo9           |                         |           |                         |     |          |      |
|                                                      | F-nr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | 6                          |                         |           |                         |     |          |      |
|                                                      | FM                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | 4                          |                         |           |                         |     |          |      |
| CONVIENT POUR                                        | 9%Cr-1% Mo ISO 15608: ~5,4 C ≤ 0,35 %, 7,0 % ≤ Cr < 10,0 % und 0,7 < Mo ≤ 1,2 %<br>1.7386, 1.7688, 1.7389<br>X12CrMo 9 1, GX12CrMo 10 1, X11CrMo9-1, X7CrMo9-1,<br>ASTM: A182/A336 F9, A199/A213 T9, A217 C12, A234 WP9, A335 P9, A387 9, P9                                                                                                                                                                                                                                                                                                                                                  |                            |                         |           |                         |     |          |      |
| AGRÉMENTS                                            | CE                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                            |                         |           |                         |     |          |      |
| POSITIONS DE SOUDAGE                                 |        |                            |                         |           |                         |     |          |      |
| ANALYSE CHIMIQUE<br>TYPIQUE DU MÉTAL<br>D'APPORT (%) | C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | Si                         | Mn                      | Cr        | Ni                      | Mo  | V        | Cu   |
|                                                      | 0.09                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | 0.4                        | 0.55                    | 9         | 0.1                     | 0.9 | 0.02     | 0.05 |
| PROPRIÉTÉS MÉCANIQUES                                | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                | R <sub>P0,2</sub><br>(MPa) | R <sub>m</sub><br>(MPa) | A5<br>(%) | Impact Energy (J) ISO-V |     | Hardness |      |
|                                                      | 745°C±15°C 1h                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | 550                        | 660                     | 26        | RT                      |     | HRc      |      |
| ETUVAGE                                              | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                            |                         |           |                         |     |          |      |
| GAS ACC. EN ISO 14175                                | I1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                            |                         |           |                         |     |          |      |



# CEWELD ER 80S-B8 Tig

ER 80S-B8 TIG 1,6 X  
1000MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Tube      | 5       | 8720663416797 |

ER 80S-B8 TIG 2,0 X  
1000MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Tube      | 5       | 8720663416810 |

ER 80S-B8 TIG 2,4 X  
1000MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Tube      | 5       | 8720663416834 |