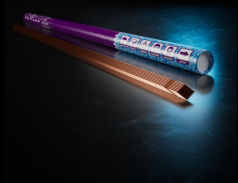


# CEWELD ER 80S-B3L Tig

|                                                   |                                                                                                                                                                                                                                                                                                                                                        |                         |                      |        |                         |     |          |
|---------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------|----------------------|--------|-------------------------|-----|----------|
| 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                                     | For 2.5%Cr-1%Mo-alloyed, heat-resistant, ferritic steels of the same type.<br>1.7380, 1.7379<br>10CrMo 9-10, G-17CrMo 9-10, GS-18 CrMo 9 10<br><b>ASTM:</b> A182 F22, A199/A200 grades T21/T22, A213 T22, A217 WC9, A234 WP22, A335 P22, A387 grades 21/22<br><b>AFNOR/BSI:</b> 10CD9-10, SS7380, 10H2M, B.S. grade 45, K21390, K21590, J22091, J21890 |                         |                      |        |                         |     |          |
| GOEDKEURINGEN                                     | CE                                                                                                                                                                                                                                                                                                                                                     |                         |                      |        |                         |     |          |
| LASPOSITIES                                       |                                                                                                                                                                                                                                                                      |                         |                      |        |                         |     |          |
| TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%) | C                                                                                                                                                                                                                                                                                                                                                      | Si                      | Mn                   | P      | S                       | Cr  | Mo       |
|                                                   | 0.03                                                                                                                                                                                                                                                                                                                                                   | 0.6                     | 0.6                  | 0.01   | 0.01                    | 2.5 | 1        |
| MECHANISCHE WAARDEN                               | Heat Treatment                                                                                                                                                                                                                                                                                                                                         | R <sub>p0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A5 (%) | Impact Energy (J) ISO-V |     | Hardness |
|                                                   |                                                                                                                                                                                                                                                                                                                                                        |                         |                      |        | 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 |