ER80S-B2 TIG

TOP FEATURES

- TIG wire for welding 1¼Cr-½Mo creep resisting steels
- High degree of purity with stringently controlled trace elements including As, Sb and Sn, and guaranteed X-factor ≤ 12 ppm
- High resistance to long term temper embrittlement
- Designed for prolonged elevated temperature service up to 550°C

CLASSIFICATION

AWS A5.28M	ER80S-B2
EN ISO 21952-B	W 1CM

SHIELDING GASES (ACC. EN ISO 14175)

I1	Inert gas Ar (100%)

TYPICAL APPLICATIONS

- Oil refinery equipment
- Thermal power plant components
- Petrochemical and chemical plants

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL

	C	Mn	Si	S	P	Cr	Mo	Ni	Cu
Typical	0.10	0.5	0.5	0.01	0.015	1.3	0.5	<0.1	0.10

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition	0.2% Proof strength (MPa)	Tensile strength (MPa)	Elongation (%)		Impact ISO-V (J) -10°C	Hardness	
				4d	5d		(HV)	(HB)
Required: AWS A5.28M		470	550	19	17	-	-	-
Typical values	PWHT	520	635	27	25	200	220	215

PWHT = Postweld Heat treatment 690°C/4h

- = not specified

AVAILABLE SIZES AND PACKAGING INFORMATION

Diameter x Length (mm)	Packaging	Weight (kg)	Item number
2.4	PE Tube	5.0	TER80SB2-24
3.2	PE Tube	5.0	TER80SB2-32

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:

Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.