

ER80S-B2 MIG

TOP FEATURES

- Solid wire for MIG welding 1½Cr-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

TYPICAL APPLICATIONS

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

CLASSIFICATION

AWS A5.28	ER80S-B2
EN ISO 21952-B	G 55 M21 1CM

SHIELDING GASES (ACC. EN ISO 14175)

M21	Mixed gas Ar+ 15-25% CO ₂
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CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, WIRE

	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	Temperature	0.2% Proof strength (MPa)	Tensile strength (MPa)	Elongation (%)		Impact ISO-V (J)		Hardness	
					4d	5d	+20°C	-10°C	(HV)	(HB)
Required: AWS A5.28			470	550	19	17	-	-	-	-
Typical values	PWHT	700°C/1h	530	635	23	21	160	-	-	-
	PWHT	690°C/4h	480	590	26	24	-	115	195	190

PWHT = Postweld Heat treatment

- = not specified

AVAILABLE SIZES AND PACKAGING INFORMATION

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.2	SPOOL	15.0	MER80SB2-12

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.