

ES TIG 80S-B2

GTAW
ER80S-B2

ESWECO
The Art of Welding

Description

ES TIG 80S-B2 is a 1.3Cr-0.5Mo-alloyed (ER80S-B2), copper-coated rod for the GTAW of creep-resistant steels like SA-387 Grade 11, A, 335 Grade P11 or similar materials.

ER TIG 80S-B2 finds applications in the chemical industry, in the ammonia synthesis process, for heat exchangers, boilers, piping, Steam piping, Turbine castings and pressure vessels for temperature service up to about 1020°F (550°C).

Current

DC (-)

Classifications

SFA/AWS A5.28 ER80S-B2

Typical all weld metal composition, %

C	Si	Mn	Cr	Mo
0.09	0.6	0.6	1.4	0.5

Typical mech. Properties all weld metal

Yield stress, MPa	640
Tensile strength, MPa	730
Elongation, %	24

Charpy V

Test temps, °C	Impact values, J
-40	>47

Welding parameters

Diameter, mm	Length, mm	Weight of rods/box, kg
1.6	1000	5.0
2.0	1000	5.0
2.4	1000	5.0
3.2	1000	5.0