

# CEWELD ER 80S-B3L

## Tig

**TYPE** Copper coated TIG welding wire for welding creep and hydrogen –resistant steels. (2.25% Cr and 1% Mo, B3L Type)

**APPLICATIONS** 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.

**PROPERTIES** 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.

**CLASSIFICATION**

AWS	A 5.28: ER80S-B3L
EN ISO	21952-B: W 2C1ML
F-nr	6
FM	3

**SUITABLE FOR** **For 2.5%Cr-1%Mo-alloyed, heat-resistant, ferritic steels of the same type.**  
 1.7380, 1.7379  
 10CrMo 9-10, G-17CrMo 9-10, GS-18 CrMo 9 10  
**ASTM:** A182 F22, A199/A200 grades T21/T22, A213 T22, A217 WC9, A234 WP22, A335 P22, A387 grades 21/22  
**AFNOR/BSI:** 10CD9-10, SS7380, 10H2M, B.S. grade 45, K21390, K21590, J22091, J21890

**APPROVALS** CE

**WELDING POSITIONS**

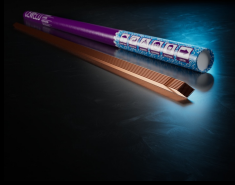


TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn	P	S	Cr	Mo
	0.03	0.6	0.6	0.01	0.01	2.5	1

MECHANICAL PROPERTIES	Heat Treatment	R <sub>P0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness
					RT		
	690°C±15°C 1h	490	560	18	100		HRc

**REDRYING** 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