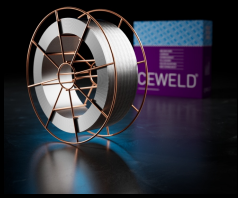


CEWELD ER 80S-B8

TYPE	Copper-coated medium alloyed welding wire for welding creep and hydrogen pressure resistant steels. 9%Cr-alloyed steels (CrMo9, B8					
APPLICATIONS	CEWELD® ER 80S-B8 is a solid wire with 9% Cr and 1% Mo to be used for welding creep resistant steel. It finds applications in power plants, chemical or petro-chemical industry and in the ammonia synthesis process. It is also used for heat exchangers, boilers, piping and pressure vessels for temperature service up to 600°C.					
PROPERTIES	CEWELD® ER 80S-B8 is more corrosion resistant than the requirements for 5%Cr-0.5%Mo steels. .					
CLASSIFICATION	AWS	A 5.28: ER 80S-B8				
	EN ISO	21952-A: G CrMo9				
	F-nr	6				
	FM	4				
SUITABLE FOR	9%Cr-1%Mo ISO 15608: $5.4 \text{ C} \leq 0,35 \text{ \%, } 7,0 \text{ \%} \leq \text{Cr} < 10,0 \text{ \% und } 0,7 < \text{Mo} \leq 1,2 \text{ \%}$ 1.7386, 1.7388, 1.7389 BS 3100 Gr B6, BS 3604 Gr CFS 629-470, HFS 629-470, BS 3604 Gr HFS 629-590, CFS 629-590, GS-12CrCrMo 10-1, X12CrMo 9-1, X7CrMo 9-1 ASTM: A182 Gr F9, A199 Gr T9 , A213 Gr T9 , A217 Gr C12 , A234 Gr WP9, A335 Gr 9, A336 Gr F9, A387 Gr 9,					
APPROVALS	CE					
WELDING POSITIONS						
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn	Cr	Mo	Other
	0.08	0.41	0.53	9.15	1.05	0.03
MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V	Hardness
	745°C±15°C 1h	490	600	20	RT	HRc
REDRYING	Not required					
GAS ACC. EN ISO 14175	M21					



CEWELD ER 80S-B8

ER 80S-B8 1,2MM

Packaging	KG/unit	EanCode
BS-300	2	8720663416865