



CEWELD ER 80S-B2 Tig

TYPE	Copper coated welding rod for welding creep resistant ferritic steels. (ER 80S-B2, G 1CM)					
APPLICATIONS	CEWELD® ER 80S-B2 Tig is a Filler metal for high temperature creep resistant 1.25%Cr0.5%Mo ferritic steel. Preferably used for steels 13CrMo4-5 or ASTM A335 P11/P12. CEWELD® ER 80S-B2 Tig are used for creep resisting applications up to ~550°C. Typical applications in power generation plant include steam piping, turbines and boilers; the alloy also finds applications in the chemical and petro-chemical industries.					
PROPERTIES	The CEWELD® ER 80S-B2 Tig has low levels of tramp elements (e.g. Sn, As, Sb and P) providing a low Bruscato Factor($X < 10$ ppm)for temper embrittlement resistant applications.					
CLASSIFICATION	AWS	A 5.28: ER 80S-B2				
	EN ISO	21952-B: W 1CM				
	F-nr	6				
	FM	3				
SUITABLE FOR	For matching 1.25%Cr 0.5%Mo creep resisting ferritic steels. 13CrMo4-5, 16CrMo4-4, GS-17CrMo5-5 ASTM: A182 grades F11/F12, A199/A200 T11, A217 grades WC6/WC11, A234 grades WP11/WP12, A335 grades P11/P12, A387 grades 11/12					
APPROVALS	CE					
WELDING POSITIONS						
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn	Cr	Mo	
	0.09	0.6	0.6	1.3	0.5	
MECHANICAL PROPERTIES	Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V	Hardness
	620°C±15°C 1h	560	660	24	RT	
					200	HRc
REDRYING	Not required					
GAS ACC. EN ISO 14175	I1					



CEWELD ER 80S-B2 Tig

ER 80S-B2 TIG 1,6MM

Packaging	KG/unit	EanCode
Tube	5	8720663417466

ER 80S-B2 TIG 2,0 X
1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663417480

ER 80S-B2 TIG 2,4 X
1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663417497

ER 80S-B2 TIG 3,2 X
1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663417527