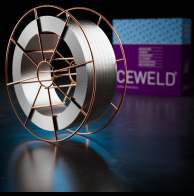




CEWELD ER 80S-B8

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 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 (%)	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>Cr</th> <th>Mo</th> <th>Other</th> </tr> </thead> <tbody> <tr> <td>0.08</td> <td>0.41</td> <td>0.53</td> <td>9.15</td> <td>1.05</td> <td>0.03</td> </tr> </tbody> </table>	C	Si	Mn	Cr	Mo	Other	0.08	0.41	0.53	9.15	1.05	0.03					
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745°C±15°C 1h	490	600	20	110		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