CEWELD ER 80S-B2

certilas® THE FILLER METAL SPECIALIST

TYPE

Copper coated welding wire for welding creep resistant ferritic steels.(ER 80S-B2, G 1CM)

APPLICATIONS

CEWELD® ER 80S-B2 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 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

CEWELD® ER 80S-B2 has low levels of tramp elements (eg. 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: G 1CM
F-nr	6
FM	3

SUITABLE FOR

Typ 1Cr0,5Mo, ISO 15608: ~5,1
1.7205, 1.7218, 1.7225, 1.7228, 1.7254, 1.7258, 1.7262, 1.7335, 1.7337, 1.7350, 1.7354, 1.7357, 1.7728
13CrMoV42, 13CrMo4-4, 13CrMo4-5, 15CrMo3, 15CrMo5, 13CrMoV42, 15Cr3, 16MnCr5, 20MnCr5, 15CrMo5, 24CrMo5, 25CrMo4, GS-22CrMo5, GS-22CrMo54, GS 17CrMo5-5, 16CrMoV4, 42CrMo4, 42CrMo4V, 41CrMo4V,
ASTM A 182 Gr. F11 / F12; A 193 Gr. B7; A 213 Gr. T12; A 217 Gr. WC6; A 234 Gr. WP11; A335 Gr. P11, P12; A 336 Gr. F11, F12; A 426 Gr. CP12 ; A 199; A200; A 387 Gr A11 / 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)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V RT	Hardness
660°C- 700°C 1h	470	560	20	80	HRc

REDRYING

Not required

GAS ACC. EN ISO 14175

M21

CEWELD ER 80S-B2

ER 80S-B2 0,8MM

Packaging	KG/unit	EanCode
BS-300	15	8720663424327

ER 80S-B2 1,0MM

Packaging	KG/unit	EanCode
BS-300	15	8720663417442

ER 80S-B2 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663417459