



CEWELD SA 80S-B8

TYPE Medium alloyed, high-strength 9% Chromium alloy SAW wire.

TOEPASSINGEN Low alloyed copper-coated SAW wire with 9% Cr and 1% Mo to be used for welding creep resistant steel. It finds applications in power plants, chemical or petrol-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.

EIGENSCHAPPEN The 9%Cr-1%Mo creep resistant alloy is used for service up to ~600°C particularly in environments involving hot hydrogen gas. Flux CEWELD® FL 880

CLASSIFICATIE

| | |
|--------|------------------|
| AWS | A 5.23: EB8 |
| EN ISO | 24598-A: S CrMo9 |
| F-nr | 6 |
| FM | 4 |

GESCHIKT VOOR ASTM: A 182 Gr F9, A 199 Gr T9, A 213 Gr T9, A 217 Gr C12, A 234 Gr WP9, A 335 Gr 9, A 336 Gr F9, A 387 Gr 9, EN (BS 3100 Gr B6), (BS 3604 Gr CFS 629-470, HFS 629-470), (BS 3604 Gr HFS 629-590, CFS 629-590), (DIN GS-12CrCrMo 10-1), (DIN X12CrMo 9-1), (DIN X7CrMo 9-1) W.Nr: 1.7386, 1.7388, 1.7389

GOEDKEURINGEN CE

LASPOSITIES



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

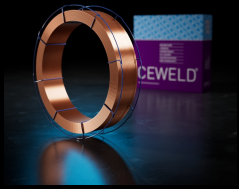
| C | Si | Mn | P | S | Cr | Ni | Mo |
|------|-----|-----|------|------|-----|------|----|
| 0.08 | 0.4 | 0.6 | 0.01 | 0.01 | 8.7 | 0.18 | 1 |

MECHANISCHE WAARDEN

| Heat Treatment | R _{PO,2} (MPa) | R _m (MPa) | A ₅ (%) | Impact Energy (J) ISO-V | | Hardness |
|-----------------|-------------------------|----------------------|--------------------|-------------------------|--|----------|
| | | | | RT | | |
| 730°C- 760°C 1h | 540 | 660 | 19 | 55 | | HRc |

HERDROGEN Not required

GAS ACC. EN ISO 14175



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SA 80S-B8 3,2MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| B-450 | 25 | 8720663416995 |