FABRICO 80S B2

SANWALKA®
Committed To Safe Welding

❖ Product Description

I. Copper coated low alloy solid wire
II. Uniform coper coating
III. The weld deposits are notch free with excellent mechanical strength
IV. Typical 1.25Cr-0.5Mo weld deposit
V. Radiographic weld quality

❖ Range of Application

I. Welding of 0.5Cr-0.5Mo, 1Cr-0.5Mo and 1.25Cr-0.5Mo steel pipes, plates and casting
II. Suitable in refineries, petrochemical and fertilizers plant
III. Can be used for joining dissimilar combinations of Cr-Mo and carbon steels

❖ Classification

• AWS/SFA 5.28 ER80S- B2

❖ % Chemical Composition

Type of Wire		C	Mn	S	Si	P	Mo	Cr	Ni	Cu	Other Elements
ER80S-B2	Min	0.07	0.40	-	0.40	-	0.40	1.20	-	-	-
	Max	0.12	0.70	0.025	0.70	0.025	0.65	1.50	0.20	0.35	0.50

❖ Mechanical Properties of all weld metal

Condition	UTS, MPa (Min)	YS, MPa (Min)	% Elongation min	Charphy "v" Notch Impact @ 0°C
PWHT	550	470	19	-

❖ Wire Size & Welding Position

• **Diameter in mm- 0.60, 0.80, 0.90, 1.00, 1.20, 1.40, 1.60**
• **Weld Position- All position**

❖ Current & Gas Flow

• **DCEP; 15-22lit/min**

❖ Packaging

Sizes Available in mm	0.60, 0.80, 0.90, 1.00, 1.20, 1.40, 1.60								
Packing Code	A	B	C	D	E	F	G	H	I
Packing Available	SD 100	SD200	SD270	SD 270	SD300	SD300	100kg Drum Pack	250kg Drum Pack	350kg Drum Pack
Net Weight of Wire	1KG	2KG	12.5KG	15KG	12.5KG	15KG	100KG	250KG	350KG

Special Notes: -

(1) All the value above mentioned are typical values.
(2) Usually all chemistry and mechanical properties will depend on actual wire chemistry and arc voltage used for welding.