

## ❖ Product Description

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|--|---|
| I. Copper coated low alloy solid wire                              | IV. The weld deposit in typical 9Cr-1Mo |
| II. Uniform copper coating   | V. Air hardenable alloy                 |
| III. Requires careful control over pre heat, interpass temperature | VI. Radiographic weld quality           |

## ❖ Range of Application

- |   |   |
|---|---|
| I. Welding of 9Cr-1Mo type and equivalent materials in pipe and tube form | III. Finds application in power plants, oil refineries, chemical and petrochemical industries |
| II. Suitable for welding ferrite and martensitic chrome steels            | IV. For corrosion and in heat resistant application   |

## ❖ Classification

- AWS/SFA 5.28 ER80S- B8

## ❖ % Chemical Composition

Type of Wire		C	Mn	S	Si	P	Mo	Cr	Ni	Cu	Other Elements
ER80S- B8	Min	-	0.40	-	-	-	0.80	8.00	-	-	-
	Max	0.10	0.70	0.025	0.50	0.025	1.20	10.50	0.50	0.35	0.50

## ❖ Mechanical Properties of all weld metal

Condition	UTS, MPa (Min)	YS, Mpa (Min)	% Elongation	Charpy "v" Notch Impact @ 0°C
PWHT	550	470	17	-

## ❖ 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.

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