

❖ Product Description

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| <p>I. The wire is copper coated for creep-resistant steels like SA-387 Grade 11, A335 Grade P11 and equivalent materials.</p> <p>II. A necessary control of pre-heat, interpass temperature & PWHT is essential to avoid cracking</p> | <p>III. Copper coating is uniform</p> <p>IV. The wire feeding is smooth</p> <p>V. Radiographic weld quality</p> |
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❖ Range of Application:

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| <p>I. Suitable for welding of 0.5Cr-0.5Mo, 1Cr-0.5Mo and 1.25Cr-0.5Mo steel pipes, plates and casting</p> <p>II. Effective application where temperature and corrosive service applications in refineries, petrochemical and fertilizers plant</p> | <p>III. Can be used for welding dissimilar metal combinations such as Cr-Mo and various carbon steels</p> |
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❖ Classification:

- AWS/SFA 5.28 ER80S-B2

❖ Chemical Composition

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

❖ Mechanical Properties of all weld metal

Condition	UTS, MPa (Min)	YS, MPa (Min)	% Elongation	Charpy "v" Notch Impact @ 0°C
As Welded	550	470	19	-

❖ Wire Size & Weld Position

- Diameter in mm-1.6, 2.0 2.40,3.20,4.00 and 5.00
- All position

❖ Current and Gas- Flow Rate

- DCEN & 8-15 lit/min

❖ Packaging

Sizes available in cut length of 1000mm	1.60,2.00,2.40,3.20,4.00,5.00			
Packing Code	A		B	
Packing Available	5kg PLASTIC TUBE	20KG BOX	10KG PAPER TUBE	20KG BOX
Net Weight of Wire	5	20	10	20

Special Note: -

All the value above mentioned are typical values.

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- Usually all chemistry and mechanical properties will depend on actual wire chemistry and arc voltage used for welding.

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