

## ❖ Product Description

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| <p>I. The wire is copper coated low alloy steel filler wire</p> <p>II. The copper coating is uniform for smooth wire flow</p> | <p>III. Especially for 5%Cr-0.50%Mo creep resisting steel</p> <p>IV. Effective where there is requirement of high strength</p> <p>V. Better corrosion resistance</p> |
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## ❖ Range of Application:

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| <p>I. Suitable for high temperatures and high pressure vessels</p> | <p>II. Can be used for welding boilers, heat exchangers, piping and pressure vessels where good weld strength is mandatory</p> <p>III. Suitable for welding high strength steels</p> |
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## ❖ Classification:

- AWS/SFA 5.28 ER80S-B6

## ❖ Chemical Composition

Type of Wire		C	Mn	Si	S	P	Cu	Ni	Cr	Mo	Other Elements Total
ER80S-B6	Min	-	0.40	-	-	-	-	-	4.50	0.45	-
	Max	0.10	0.70	0.50	0.025	0.025	0.035	0.60	6.00	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	17	-

## ❖ 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.

### **SHAKUNT ENTERPRISES PRIVATE LIMITED**

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**Vadodara Works:-** 67-A, G.I.D.C, Majusar, Savli, Vadodara-397115 (GUJARAT) **INDIA**

## FABTIG 80S B6



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



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