

❖ Product Description

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| I. The wire is copper coated low alloy steel filler wire | III. Control over pre-heat, inter pass temperatures required |
| II. The copper coating is uniform for smooth wire flow | IV. Highly resistant to elevated temperature creep and heat |
| | V. The weld produced is Radiographic quality |

❖ Range of Application:

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| I. Suitable for ferritic martensitic chrome steels | IV. Effective in general corrosion and heat resistance application |
| II. For joining materials of similar composition | |
| III. Can be used in chemical and petrochemical industries | |

❖ Classification:

- AWS/SFA 5.28 ER80S-B8

❖ Chemical Composition

Type of Wire		C	Mn	Si	S	P	Ni	Cu	Cr	Mo	Cu	Other Elements Total
ER80S-B8	Min	-	0.40	-	-	-	-	-	8.00	0.80	-	-
	Max	0.10	0.70	0.50	0.025	0.025	0.50	0.035	10.00	1.20	0.35	0.50

❖ Mechanical Properties of all weld metal

Condition	UTS, Mpa (Min)	YS, Mpa (Min)	% Elongation	Charphy "v" Notch Impact @ 0°C
As Welded	550	470	17	-

❖ Wire Sizes & Wed 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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(2) Usually all chemistry and mechanical properties will depend on actual wire chemistry and arc voltage used for welding.

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