

CEWELD ER 80S-B3L

TYPE	Copper coated Solid welding wire for welding creep and hydrogen – resistant steels. (2.25% Cr and 1% Mo, B3L Type)						
APPLICATIONS	CEWELD® ER 80S-B3L finds applications in the chemical industry, in the ammonia synthesis process, for heat exchangers, boilers, piping, and pressure vessels for temperature service up to about 600°C. It will also find applications in the petro-chemical industries, as it is suitable for facing on castings and for casting repairs.						
PROPERTIES	CEWELD® ER 80S-B3L is a low alloy copper-coated TIG rod with 2.25% Cr and 1% Mo content, with low carbon content (less than 0.05%), to be used for welding creep resistant steels.						
CLASSIFICATION	AWS	A 5.28: ER80S-B3L					
	EN ISO	21952-B: G 2C1ML					
	F-nr	6					
	FM	3					
SUITABLE FOR	For 2.5%Cr-1%Mo-alloyed, heat-resistant, ferritic steels of the same type. 1.7380, 1.7379 10CrMo 9-10, G-17CrMo 9-10, GS-18 CrMo 9 10 ASTM: A182 F22, A199/A200 grades T21/T22, A213 T22, A217 WC9, A234 WP22, A335 P22, A387 grades 21/22 AFNOR/BSI: 10CD9-10, SS7380, 10H2M, B.S. grade 45, K21390, K21590, J22091, J21890						
APPROVALS	CE						
WELDING POSITIONS							
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	P	S	Cr	Mo
	0.03	0.6	0.6	0.015	0.015	2.5	1
MECHANICAL PROPERTIES	Heat Treatment		R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness	
	690°C±15°C 1h		490	560	18	HRc	
REDRYING	Not required						
GAS ACC. EN ISO 14175	M21						