CEWELD ER 80S-B8

certilas® THE FILLER METAL SPECIALIST

TYPE	Medium alloyed, high-strength 9% Cromium Alloy.
APPLICATIONS	Low alloyed copper-coated solid wire with 9% Cr and 1% Mo to be used for welding creep resistant steel. It finds applications in power plants, chemical or petro-chemical industry and in the ammonia synthesis process. It is also used for heat exchangers, boilers, piping and pressure vessels for temperature service up to 600°C.
PROPRIÉTÉS	Corrosion resistance is higher than 5%Cr-0.5%Mo steels requirements. To be used with shielding gas Ar+02.

CLASSIFICATION

AWS	A 5.28: ER 80S-B8
EN ISO	21952-A: G CrMo9
F-nr	6
FM	4

CONVIENT POUR

9%Cr-1%Mo ISO 15608: 5.4 C ≤ 0,35 %, 7,0 % ≤ Cr < 10,0 % und 0,7 < Mo ≤ 1,2 %
1.7386, 1.7388, 1.7389
BS 3100 Gr B6, BS 3604 Gr CFS 629-470, HFS 629-470, BS 3604 Gr HFS 629-590, CFS 629-590, GS-12CrCrMo 10-1, X12CrMo 9-1, X7CrMo 9-1
ASTM: A182 Gr F9, A199 Gr T9 , A213 Gr T9 , A217 Gr C12 , A234 Gr WP9, A335 Gr 9, A336 Gr F9, A387 Gr 9,

AGRÉMENTS: CE

POSITIONS DE SOUDAGE

ANALYSE CHIMIQUE TYPIQUE DU MÉTAL D'APPORT (%)

C	Si	Mn	Cr	Mo	Other
0.08	0.41	0.53	9.15	1.05	0.03

PROPRIÉTÉS MÉCANIQUES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V	Hardness
				RT	
745°C±15°C 1h	490	600	20	110	HRc

ETUVAGE: Not required

GAS ACC. EN ISO 14175: M21

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ER 80S-B8 1,2MM

Packaging	KG/unit	EanCode
BS-300	2	8720663416865