



CEWELD ER 80S-B8 Tig

TYPE	Solid GTAW Welding wire for welding creep resistant steel (Type P9)							
APPLICATIONS	CEWELD® ER 80S-B8 Tig is a 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.							
PROPERTIES	CEWELD® ER 80S-B8 Tig is more corrosion resistant than the requirements for 5%Cr-0.5%Mo steels.							
CLASSIFICATION	AWS	A 5.28: ER 80S-B8						
	EN ISO	21952-A: W CrMo9						
	F-nr	6						
	FM	4						
SUITABLE FOR	9%Cr-1% Mo ISO 15608: ~5,4 C ≤ 0,35 %, 7,0 % ≤ Cr < 10,0 % und 0,7 < Mo ≤ 1,2 % 1.7386, 1.7688, 1.7389 X12CrMo 9 1, GX12CrMo 10 1, X11CrMo9-1, X7CrMo9-1, ASTM: A182/A336 F9, A199/A213 T9, A217 C12, A234 WP9, A335 P9, A387 9, P9							
APPROVALS	CE							
WELDING POSITIONS	 PA  PB  PC  PD  PE  PF  PG							
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn	Cr	Ni	Mo	V	Cu
	0.09	0.4	0.55	9	0.1	0.9	0.02	0.05
MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness	
					RT			
	745°C±15°C 1h	550	660	26	60		HRc	
REDRYING	Not required							
GAS ACC. EN ISO 14175	I1							



CEWELD ER 80S-B8 Tig

ER 80S-B8 TIG 1,6 X
1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663416797

ER 80S-B8 TIG 2,0 X
1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663416810

ER 80S-B8 TIG 2,4 X
1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663416834