

ER80S-B2

TIG (GTAW)

LOW ALLOY STEELS

1¼Cr-½Mo CREEP RESISTING STEEL TIG WIRE

PRODUCT DESCRIPTION

Wire for TIG welding 1¼Cr-½Mo creep resisting steels, conforming to the AWS/ASME specification.

CLASSIFICATIONS

AWS A5.28M ER80S-B2
ISO 21952-B W 1CM

ASME IX QUALIFICATION

QW432 F-No 6
QW442 A-No 3

CHEMICAL COMPOSITION (WIRE WT %)

	C	Mn	Si	S	P	Cr	Mo	Ni	Cu
Min.	0.07	0.4	0.4	-	-	1.2	0.4	-	-
Max.	0.12	0.7	0.7	0.020	0.020	1.5	0.65	0.2	0.35
Typical	0.10	0.5	0.5	0.01	0.015	1.3	0.5	<0.1	0.10

ALL-WELD MECHANICAL PROPERTIES

Properties after PWHT	Min.	Typical 690°C/4h
Tensile strength [MPa]	550	635
0.2% proof strength [MPa]	470	520
Elongation [%] 4d	19	27
5d	17	25
Impact ISO-V(J) -10°C	-	>200
Hardness [HV]	-	220
[HB]	-	215

TYPICAL OPERATING PARAMETERS

Shielding gas	Current	Diameter (mm)	Parameters
Argon	DC-	2.4	100A, 12V

PACKAGING DATA

Diameter (mm)	Weight (kg)	Packaging	Item number
1.6	5	PE TUBE	TER80SB2-16
2.0	5	PE TUBE	TER80SB2-20
2.4	5	PE TUBE	TER80SB2-24
3.2	5	PE TUBE	TER80SB2-32

All information in this data sheet is accurate to the best of our knowledge at the time of printing. Please refer to www.specialalloys.eu for any updated information.