



AUTOMIG 80S-B8

GMAW LOW ALLOY STEEL (High Temperature)

AWS A/SFA 5.28 **ER80S-B8**

CLASSIFICATION:

EN ISO 21952-B
G 55 M13 9C1M

KEY FEATURES:

- Copper coated low alloy steel solid filler wire & rod
- Uniform copper coating
- Careful control over pre-heat, interpass temperature required
- Typical 9 Cr-1 Mo weld deposit
- Air hardenable alloy highly resistant to elevated temperature creep and heat
- Radiographic quality weld

APPROVALS: CE

TYPICAL APPLICATIONS:

- Welding of 9Cr-1Mo type and equivalent materials in pipe and tube forms
- Welding of ferritic martensitic chrome steels
- For general corrosion and heat resistance application
- Joining P9/T9 materials of similar composition
- Application in Power plants, Oil refineries, Chemical and Petrochemical industries

TYPICAL CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt %:

C	Mn	Si	Cr	Mo
0.08	0.55	0.45	8.7	1.0

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%
Specification	PWHT: 745°C for 1 hr	630	570	20

PARAMETERS - PACKING DATA:

Ø, mm	Kg/Spool		
1.2	15	 DCEP STORAGE / HANDLING : Keep dry and follow handling instructions mentioned on the box	All Positions 
1.6	15		

Shielding Gas	Gas Flow Rate, LPM
Ar/1-5O ₂	15-22