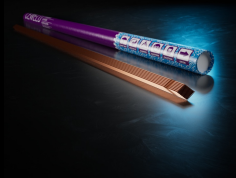


# CEWELD ER 80S-B3L Tig

|                                                      |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                            |                         |           |                         |     |          |
|------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------|-------------------------|-----------|-------------------------|-----|----------|
| TYPE                                                 | Copper coated TIG welding wire for welding creep and hydrogen –resistant steels.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                            |                         |           |                         |     |          |
| APPLICATIONS                                         | CEWELD® ER 80S-B3L Tig 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.                                                                                                                                                                                                                                                       |                            |                         |           |                         |     |          |
| PROPRIÉTÉS                                           | CEWELD® ER 80S-B3L Tig 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: W 2C1ML           |                         |           |                         |     |          |
|                                                      | F-nr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | 6                          |                         |           |                         |     |          |
|                                                      | FM                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | 3                          |                         |           |                         |     |          |
| CONVIENT POUR                                        | <b>For 2.5%Cr-1%Mo-alloyed, heat-resistant, ferritic steels of the same type.</b><br>1.7380, 1.7379<br>10CrMo 9-10, G-17CrMo 9-10, GS-18 CrMo 9 10<br><b>ASTM:</b> A182 F22, A199/A200 grades T21/T22, A213 T22, A217 WC9, A234 WP22, A335 P22, A387 grades 21/22<br><b>AFNOR/BSI:</b> 10CD9-10, SS7380, 10H2M, B.S. grade 45, K21390, K21590, J22091, J21890                                                                                                                                                                                                                                        |                            |                         |           |                         |     |          |
| AGRÉMENTS                                            | CE                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                            |                         |           |                         |     |          |
| POSITIONS DE SOUDAGE                                 |        |                            |                         |           |                         |     |          |
| ANALYSE CHIMIQUE<br>TYPIQUE DU MÉTAL<br>D'APPORT (%) | C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | Si                         | Mn                      | P         | S                       | Cr  | Mo       |
|                                                      | 0.03                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | 0.6                        | 0.6                     | 0.01      | 0.01                    | 2.5 | 1        |
| PROPRIÉTÉS MÉCANIQUES                                | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | R <sub>p0,2</sub><br>(MPa) | R <sub>m</sub><br>(MPa) | A5<br>(%) | Impact Energy (J) ISO-V |     | Hardness |
|                                                      | 690°C±15°C 1h                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | 490                        | 560                     | 18        | RT                      |     | HRc      |
| ETUVAGE                                              | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                            |                         |           |                         |     |          |
| GAS ACC. EN ISO 14175                                | I1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                            |                         |           |                         |     |          |



# CEWELD ER 80S-B3L Tig

ER 80S-B3L TIG 2,4 X  
1000MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Tube      | 5       | 8720663417510 |

ER 80S-B3L TIG 3,2 X  
1000MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Tube      | 5       | 8720663417534 |