

ST-80B6

Conformances

AWS A5.28/ ASME SFA5.28 ER80S-B6

EN ISO 21952-A W CrMo5Si

Applications

- It will find applications in 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

Features

- Low alloy copper-coated tig rod with 5% Cr and 0.5% Mo content to be used for the welding of creep resistant steel

Welding Position

Current

GTAW: DC-

Shielding Gas

Ar

Diameter / Packaging

Diameter	Length mm(in)
mm (in)	5kg (11lbs)
2.0 (5/64)	✓
4.0 (5/32)	✓
5.0 (3/16)	✓

Typical Chemical Composition of the Wire (%)

C	Si	Mn	S	P	Cu	Ni	Cr
0.085	0.386	0.537	0.005	0.006	0.138	0.052	5.610
Mo	V	Nb	Sb	Sn	As	X-Factor	
0.558	0.010	0.003	0.002	0.004	0.002	8.81 ppm	

Typical Mechanical Properties of All-Weld Metal

YS Mpa(lbs/in ²)	TS Mpa(lbs/in ²)	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft-lbs)	PWHT
594 (86,000)	676 (98,000)	23.9	-20 (-4)	257 (198)	745°C × 1hr

SMW

SAW

GMW

GTAW

FCW

Non-FERROUS

APPENDIX