S-8015.B8

Type : Basic

Conformances

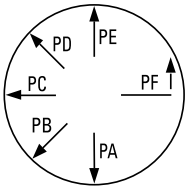
AWS A5.5/ ASME SFA5.5 E8015-B8

EN 1599 - ECrMo9 B 3 2 H5

Applications

- Pressure vessels
- Powder plant
- Low alloy steel (9%Cr-1%Mo)

Welding Position



Features

- 9% Cr Steel Welding for superheated pipe (boilers and refinery)
- Good resistance for high temperature creep
- Anti-temperature / Anti-Corrosion

Current

DC +

Redrying Conditions

350~400°C (662~752°F) X 0.5~1hr

Diameter / Packaging

Diameter	Length	Standard		Vacuum	
mm (in)	mm (in)	packet 5kg(11lbs)	carton 20kg(44lbs)	packet 5kg(11lbs)	carton 20kg(44lbs)
2.6 (3/32)	350 (14)	√		√	
3.2 (1/8)	350 (14)	√		√	
4.0 (5/35)	400 (16)	√		√	
5.0 (3/16)	400 (16)	√		√	

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr	Ni	Mo
0.08	0.27	0.72	0.008	0.005	8.81	0.19	0.94

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in²)	TS MPa(lbs/in²)	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft·lbs)	Heat Treatment
628 (91,100)	721 (104,600)	23.4	20 (68) 0 (32)	36 (27) 32 (24)	740°C(1364°F) X 1hr

Typical Welding Parameters / Amp.(A)

Diameter mm (in)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)
Length mm (in)	350 (14)	400 (16)	400 (16)	450 (18)
F	70~100	90~130	130~170	170~220
V-up, OH	60~90	80~120	100~150	-