

# ST-80B2R

Type : TIG

## Conformances

AWS A5.28/ ASME SFA5.28 ER80S-B2

## Applications

- High pressure pipe & Pressure vessels

## Features

- Careful control of preheat, interpass temperatures, postheat is essential to avoid cracking.
- For welding 0.5~1.25Cr-0.5Mo steels for elevated temperatures and corrosive service
- X-factor value of wire is 10ppm or less

## Welding Position

## Current

GTAW: DC-

## Shielding Gas

Ar

## Diameter / Packaging

Diameter	Length mm(in)
mm (in)	5kg (11lbs)
2.0 (5/64)	✓
2.4 (3/32)	✓
3.2 (1/8)	✓

## Typical Chemical Composition of the Wire (%)

C	Si	Mn	S	P	Cu	Ni	Cr
0.095	0.49	0.645	0.011	0.008	0.12	0.021	1.320
Mo	V	Al	Nb	Sb	Sn	As	X-Factor
0.48	0.002	0.002	0.002	0.001	0.002	0.003	9.6 ppm

## Typical Mechanical Properties of All-Weld Metal

YS Mpa(lbs/in <sup>2</sup> )	TS Mpa(lbs/in <sup>2</sup> )	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft-lbs)	PWHT
490 (71,000)	580 (84,100)	22	20 (68)	120 (88.5)	620°C × 1hr

SMW

SAW

GMW

GTAW

FCW

Non-FERROUS

APPENDIX