

ST-80B8

Type : TIG

Conformances

AWS A5.28/ ASME SFA5.28 ER80S-B8

EN ISO 21952-A W CrMo9

Applications

- It will find applications in power plants, chemical or petrochemical 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 9% Cr and 1% 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)	✓
2.4 (3/32)	✓
3.2 (1/8)	✓

Typical Chemical Composition of the Wire (%)

C	Si	Mn	S	P	Cu	Ni	Cr
0.06	0.33	0.49	0.005	0.006	0.150	0.230	8.740
Mo	V	Nb	Sb	Sn	As	Al	X-Factor
0.970	0.021	0.002	0.001	0.005	0.003	0.005	8.8 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
660 (96,000)	740 (107,000)	21	-20 (-4)	132 (97)	745°C × 1hr