

GETIG 80S-B6

IDENTIFICATION

Getig 80SB6, ER 80SB6

CLASSIFICATION

AWS A 5.28 ER 80S-B6

DESCRIPTION

Copper coated filler wire for welding 5% Cr / 0.5% Mo, air hardening steel used for elevated temperature, creep service and corrosion resistance against steam, hot hydrogen gas and high sulphur crude oils. The welds are of radiographic quality.

CHEMICAL ANALYSIS (RANGE) %

C	Mn	Si	Cr	Cu	Ni	Mo	S	P
0.10 max	0.40 - 0.70	0.50 max	4.50 - 6.0	0.30 max	0.60 max	0.45 - 0.65	0.025 max	0.025 max

MECHANICAL PROPERTIES (RANGE) PWHT(745OC ±15°C/2 HRS)

TS (N/mm ²)	YS (N/mm ²)	EL (%) (L=4D)	CVN Impact Value	
			Temp	Joules
550 - 650	470 - 560	20 - 25	27 ± 2°C	30 - 80

TYPICAL APPLICATIONS

- Petrochemical & Refineries, ASTM A 335 Grs P5, P5b, A217C5.
- ASTM A199/A213 Grs T5 and T5b

SHIELDING GAS : Argon 7-10 lt/min.

WELDING CURRENT : DC (-)

PACKING PARAMETERS

Size (mm)	Length (mm)	Packing / Pkt (kg)	Packing / Box (kg)
1.6	1000	5	5 x 4 = 20
2	1000	5	5 x 4 = 20
2.40 / 2.50	1000	5	5 x 4 = 20
3.15 / 3.20	1000	5	5 x 4 = 20