

# GM 80S-B2

## IDENTIFICATION

GM 80SB2, ER 80SB2

## CLASSIFICATION

AWS/SFA 5.28 ER 80S-B2, DIN 8575-84 SGCr Mo 1

## DESCRIPTION

Copper coated solid wires alloyed 1.25% Cr/0.5% Mo intended for welding creep resisting steels of similar composition used in power generating plant operating at temperature up to 570°C. Deposited weld metal meets X-ray quality.

## CHEMICAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Cr	Mo	Cu
0.07 - 0.12	0.40 - 0.70	0.40 - 0.70	0.025 max	0.025 max	1.2 - 1.5	0.40 - 0.65	0.35 max

## MECHANICAL PROPERTIES (RANGE)

TS (N/mm <sup>2</sup> )	YS (N/mm <sup>2</sup> )	EL (%) (L=4D)
550-640	470 - 540	20 - 26

## TYPICAL APPLICATIONS

In general usable on the following grades of creep resistant steels.

- 1 Cr<sup>1</sup>/<sub>2</sub> Mo steels such as ASTM A 387 Gr. B, DIN steels 13 Cr Mo44-GS-17Cr Mo55, A335 Gr. P11 and P12
- ASTM A199, A200, A213

**PREHEAT AND INTERPASS TEMPERATURE : 135 - 165°C**

**SHIELDING GAS : 99.99 % Ar, 7-12 l/min, and back purge or as per requirements.**

**WELDING CURRENT : DC (-)**

## PACKING PARAMETERS

Size (mm)	Weight / Spool / Drum (kg)
0.8	15.0 Kg
1.2	15.0 Kg
1.6	15.0 Kg
1.20 (Drum Pack)	250.0 Kg