

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

TYPICAL APPLICATIONS

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

- 1 Cr¹/₂ 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 |