

## IABCO ER80S-B6 MIG

### MIG/GMAW wire for mild and low alloy steels

Product name	IABCO ER80S-B6 MIG
Classification EN ISO	21952-A: GCrMo5Si
Material No.	1.7373
Classification AWS	A5.28: ER80S-B6
Approvals	-
Applications	MIG/GMAW wire for high temperature creep resistant 5%Cr-0.5%Mo ferritic steel. The 5%Cr-0.5%Mo creep resistant alloy is used for service up to ~600°C particularly in environments involving hot hydrogen gas. Typical applications are found in oil refineries.
Base materials	For matching 5%Cr-0.5%Mo creep resisting ferritic steels. ASTM: A182/A336 grade F5, A199/A213 grade T5, A217 grade C5, A234 grade WP5, A335 grade P5, A387 grade 5. X12CrMo5, GX12CrMo5.
Typical analysis of wire, weight %	C: 0.08 Si: 0.35 Mn: 0.55 Cr: 6.00 Mo: 0.65
Typical heat treatment <sup>(1)</sup>	Preheat temperature: 200°C. Interpass temperature: 300°C. PWHT: 745°C.
Mechanical properties of weld deposit <sup>(2)</sup>	0.2% proof stress Rp0.2%: ≥470MPa. Tensile strength Rm: ≥570MPa. Elongation 4d/5d: ≥17%.
Other products	SAW: IABCO S1CrMo5. TIG/GTAW: IABCO ER80S-B6.

- Notes** (1) Application codes and project specifications should always be referred to for specific requirements.  
(2) Actual mechanical properties will be dependent on specific welding procedure (including shielding gas, flux, PWHT etc) and should always be confirmed by approval of an appropriate welding procedure.