

## IABCO ER80S-B8 MIG

### MIG/GMAW wire for low alloy steels

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| Product name   | IABCO ER80S-B8 MIG   |
| Classification EN ISO                                | 21952-A: GCrMo9  |
| Material No.   | -  |
| Classification AWS                                   | A5.28: ER80S-B8  |
| Approvals  | -  |
| Applications   | MIG/GMAW wire for high temperature creep resistant 9%Cr-1%Mo ferritic steel. The 9%Cr-1%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 9%Cr-1%Mo creep resisting ferritic steels.<br>ASTM: A182/A336 F9, A199/A213 T9, A217 C12, A234 WP9, A335 P9, A387 9.<br>X12CrMo 9 1, GX12CrMo 10 1.<br>1.7386, 1.7688, 1.7389.  |
| Typical analysis of wire, weight %                   | C: 0.08<br>Si: 0.4<br>Mn: 0.6<br>Cr: 8.9<br>Mo: 1.0<br>Ni: 0.2   |
| Typical heat treatment <sup>(1)</sup>                | Preheat temperature: 200°C.<br>Interpass temperature: 300°C.<br>PWHT: 745°C.   |
| Mechanical properties of weld deposit <sup>(2)</sup> | 0.2% proof stress Rp0.2%: ≥470MPa.<br>Tensile strength Rm: ≥590MPa.<br>Elongation 4d/5d: ≥18%.   |
| Other products                                       | TIG/GTAW: IABCO ER80S-B8.  |

**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.