

IABCO ER80S-B8 TIG

TIG/GTAW wire for low alloy steels

Product name	IABCO ER80S-B8 TIG
Classification EN ISO	21952-A: WCrMo9
Material No.	-
Classification AWS	A5.28: ER80S-B8
Approvals	-
Applications	TIG/GTAW rod 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. ASTM: A182/A336 F9, A199/A213 T9, A217 C12, A234 WP9, A335 P9, A387 9. X12CrMo 9 1, GX12CrMo 10 1. 1.7386, 1.7688, 1.7389.
Typical analysis of wire, weight %	C: 0.08 Si: 0.4 Mn: 0.6 Cr: 8.9 Mo: 1.0 Ni: 0.2
Typical heat treatment ⁽¹⁾	Preheat temperature: 200°C. Interpass temperature: 300°C. PWHT: 745°C.
Mechanical properties of weld deposit ⁽²⁾	0.2% proof stress Rp0.2%: ≥470MPa. Tensile strength Rm: ≥590MPa. Elongation 4d/5d: ≥18%.
Other products	MIG/GMAW: 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.