

T-80SB2

For 1.25%Cr-0.5%Mo heat-resistant steel

Classifications

EN ISO 21952-B:2007	: W 55 1CM	JIS Z 3317	: W 55-1CM
AWS A5.28-05	: ER80S-B2	KS D 7140	: YGT1CM

Description

- For butt and fillet welding of power plant, heat exchanger and oil refineries such as 1.25%Cr-0.5%Mo heat-resistant steel.
- Excellent mechanical and toughness properties after PWHT.
- Proper tungsten electrode extension from the tip of torch is 4~6mm in general.
- Preheat at 100°C to 200°C and post weld heat treatment at 620°C to 720°C is necessary according to the plate thickness, type of steels, shape of base metals or under high restriction.

Typical chemical composition of rod (%)

C	Si	Mn	P	S	Cr	Mo
0.09	0.54	0.51	0.015	0.006	1.26	0.45

Typical mechanical properties of all-weld-metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J) 0°C	Remarks
AWS A5.28	min. 470	min. 550	min. 19	–	PWHT, Ar
EN ISO 21952-B	min. 470	min. 550	min. 17	–	PWHT
Example	500	590	26	80	PWHT, Ar

* PWHT : 620°Cx1Hr

Operating data

Dia.(mm)	2.4~3.2
Current (Amp.)	200 ~ 300

Polarity and Shielding gas

- DCEN (DC-)
- Ar : (15~25l/min)