



AUTOMIG 80S-B2

GMAW LOW ALLOY STEEL (High Temperature)

AWS A/SFA 5.28 **ER80S-B2**

CLASSIFICATION:

EN ISO 21952-B

G 55 M13 1CM

IS 6419

SLA-3-M-531

KEY FEATURES:

- Copper coated low alloy steel solid filler wire & rod
- Uniform copper coating
- Deposit notch free welds with excellent mechanical properties
- Typical 1.25 Cr-0.5 Mo weld deposit
- Careful control of pre-heat, interpass temperature & PWHT is essential to avoid cracking
- Radiographic quality weld

APPROVALS: IBR/CE

TYPICAL APPLICATIONS:

- Welding of 0.5Cr-0.5Mo, 1Cr-0.5Mo and 1.25Cr-0.5Mo steel pipes, plates and castings
- Elevated temperature and corrosive service applications in Refineries, Petrochemicals & fertilizers plant
- Can be used for joining dissimilar combinations of Cr-Mo and Carbon steels
- Suitable for ASTM A 199-76, A 200-75, A 213-76D, A 335 Gr.P11, A 369-76, A 387 Gr.B, DIN 15CrMo3



TYPICAL CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt %:

C	Mn	Si	Cr	Mo
0.1	0.6	0.5	1.25	0.52

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%
Typical	PWHT: 620°C for 1 hr	620	530	22

PARAMETERS - PACKING DATA:

Ø, mm	Kg/Spool		
1.2	15	 DCEP STORAGE / HANDLING : Keep dry and follow handling instructions mentioned on the box	All Positions 
1.6	15		

Shielding Gas	Gas Flow Rate, LPM
Ar/1-5O ₂	15-20