



# TIGFIL 80S-B8

GTAW LOW ALLOY STEEL (High Temperature)

AWS A/SFA 5.28 **ER80S-B8**

### CLASSIFICATION:

EN ISO 21952-B  
W 55 11 9C1M

### KEY FEATURES:

- Copper coated low alloy steel solid filler wire & rod
- Uniform copper coating
- Careful control over pre-heat, interpass temperature required
- Typical 9 Cr-1 Mo weld deposit
- Air hardenable alloy highly resistant to elevated temperature creep and heat
- Radiographic quality weld

### APPROVALS: CE

### TYPICAL APPLICATIONS:

- Welding of 9Cr-1Mo type and equivalent materials in pipe and tube forms
- Welding of ferritic martensitic chrome steels
- For general corrosion and heat resistance application
- Joining P9/T9 materials of similar composition
- Application in Power plants, Oil refineries, Chemical and Petrochemical industries



### TYPICAL CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt %:

C	Mn	Si	Cr	Mo
0.08	0.55	0.45	8.7	1.0

### MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%
Typical	PWHT: 745°C for 1 hr	630	570	20

### PARAMETERS - PACKING DATA:

Ø x L, mm	Net Wt., Kg		
1.6 x 1000	20	 <b>DCEN</b> <b>STORAGE / HANDLING :</b> Keep dry and follow handling instructions mentioned on the box	All Positions 
2.0 x 1000	20		
2.4 x 1000	20		

Shielding Gas	Gas Flow Rate, LPM
Ar	10-15

Available in Standard carton packing of 20 kg box, containing 4 plastic tubes of 5 kg each.