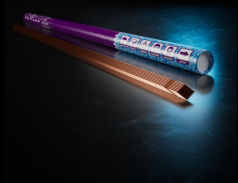


CEWELD ER 80S-B3L Tig

TYPE	Copper coated TIG welding wire for welding creep and hydrogen –resistant steels.						
APPLICATIONS	CEWELD® ER 80S-B3L Tig finds applications in the chemical industry, in the ammonia synthesis process, for heat exchangers, boilers, piping, and pressure vessels for temperature service up to about 600°C. It will also find applications in the petro-chemical industries, as it is suitable for facing on castings and for casting repairs.						
PROPRIÉTÉS	CEWELD® ER 80S-B3L Tig is a low alloy copper-coated TIG rod with 2.25% Cr and 1% Mo content, with low carbon content (less than 0.05%), to be used for welding creep resistant steels.						
CLASSIFICATION	AWS	A 5.28: ER80S-B3L					
	EN ISO	21952-B: W 2C1ML					
	F-nr	6					
	FM	3					
CONVIENT POUR	For 2.5%Cr-1%Mo-alloyed, heat-resistant, ferritic steels of the same type. 1.7380, 1.7379 10CrMo 9-10, G-17CrMo 9-10, GS-18 CrMo 9 10 ASTM: A182 F22, A199/A200 grades T21/T22, A213 T22, A217 WC9, A234 WP22, A335 P22, A387 grades 21/22 AFNOR/BSI: 10CD9-10, SS7380, 10H2M, B.S. grade 45, K21390, K21590, J22091, J21890						
AGRÉMENTS	CE						
POSITIONS DE SOUDAGE							
ANALYSE CHIMIQUE TYPIQUE DU MÉTAL D'APPORT (%)	C	Si	Mn	P	S	Cr	Mo
	0.03	0.6	0.6	0.01	0.01	2.5	1
PROPRIÉTÉS MÉCANIQUES	Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness
					RT		
	690°C±15°C 1h	490	560	18	100		HRc
ETUVAGE	Not required						
GAS ACC. EN ISO 14175	I1						



CEWELD ER 80S-B3L Tig

ER 80S-B3L TIG 2,4 X
1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663417510

ER 80S-B3L TIG 3,2 X
1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663417534