

TIGFIL 80S-B6

Classification
AWSA/SFA 5. 28 : ER80S-B6

Approvals
TOYO ER 80S-B6

Identification: AWS classification embossed at one end of the wire.

Characteristics

A GTAW/TIG filler/rod suitable for welding creep resistant 5Cr & 0.5Mo steel. It deposits notch free weld deposit with excellent mechanical properties. Good X-ray quality welds.

Typical Applications

Specially developed for welding of pipes and tubes of matching composition in power plants, Refineries, Petrochemicals and Fertilizers Plant. Chemicals and Ammonia Synthesis plants. Preheat and interpass : 250-300°C. Suitable for ASTM A 199-76, ASTM A 200 -75, ASTM A 213 - 76D, ASTM A 335 - 76, ASTM A 369 - 76, ASTM A 387 - 76.

Wire Chemistry, wt %

C	Mn	Si	S	P	Mo	Cr	Cu
0.10 max	0.60 max	0.50 max	0.025 max	0.025 max	0.45-0.65	4.60-6.00	0.35 max

Properties of weld metal with 100% Argon gas shielding **Current Condition:** DC (-)

All Weld Mechanical Properties After PWHT of 745°C for 1 hr.

UTS MPa	560-670
Yield strength MPa	470-540
Elongation % (L=4xd)	21-27
The chemistry & mechanical properties of the weld metal will vary with the type of shielding gas used.	

Packing Data

Dia (mm)	1.6	2.0	2.5
Length (mm)	1000	1000	1000
Primary Tube (Kg)	5	5	5
No. of Tubes	4	4	4
Secondary Cartons (Kg)	20	20	20

TIGFIL Wires are sealed in polyethylene bags and then packed in primary tubes.

TIGFIL Wires are also available in 5 Kg PSLW spools in 0.8, 1.0 and 1.2 mm sizes for orbital GTAW/TIG welding.



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