

TIGFIL 80S-B8

Classification
AWSA/SFA 5. 28 : ER80S-B8

Approvals
TOYO ER 80S-B8

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

Characteristics

A copper coated GTAW filler/rod having 9% Cr and 1% Mo.

Typical Applications

For welding of 9Cr-Mo steels like P9/T9 etc.

Wire Chemistry, wt % (Typical)

C	Mn	Si	S	P	Mo	Cr
0.10 max.	0.40-0.70	0.50 max.	0.025 max	0.025 max	0.80-1.20	8.00-10.50

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	550 min
Yield strength MPa	480 min
Elongation % (L=4xd)	17 min

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.



WELDERS TO THE NATION SINCE 1951
ADOR WELDING LIMITED

(Formerly Known as Advani-Oerlikon Ltd.)

www.adorwelding.com

