

Swastik Weld Make Welding Wire GMAW/GTAW (MIG & TIG) for Carbon Steel

III) ER 80S-B6 CLASSIFICATION: AWS A/SFA 5.28

Chemical Composition of ER 80S-B6 Wire

C= 0.10 max

Mn= 0.40-0.70

Si= 0.50 max

Cr= 4.50-6.0

Mo= 0.45-0.65

Ni= 0.60 max

Cu= 0.35 max

S= 0.025 max

P= 0.025 max



MECHANICAL PROPERTIES OF ALL WELD METAL :

UTS, Mpa= 560 min

EL%= 17 min

TYPICAL APPLICATION OF 80S-B6:

- 1) Typical 5 Cr-0.5 Mo weld deposit
- 2) Welding of 5 Cr-0.5 Mo Creep resistant steels and equivalent grades
- 3) Application in power generation, ammonia synthesis plants and petrochemical industries
- 4) Joining P58/T5 materials of similar composition
- 5) Joining P5B materials e.g. SA 336/336M Gr.F5, SA 387/387M Gr.5

Packing: Tig: In cut length of 1000mm in 5kgs boxes (size: 1.6, 2.0, 2.40, 3.15mm)

Mig: Continuous wire in 12.5kgs / 15kgs Plastic Spool (size: 0.80, 1.2mm)

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