



CEWELD SA 80S-B8

TYPE Medium alloyed, high-strength 9% Chromium alloy SAW wire.

APPLICATIONS Low alloyed copper-coated SAW wire with 9% Cr and 1% Mo to be used for welding creep resistant steel. It finds applications in power plants, chemical or petrol-chemical industry and in the ammonia synthesis process. It is also used for heat exchangers, boilers, piping and pressure vessels for temperature service up to ~600°C.

PROPERTIES The 9%Cr-1%Mo creep resistant alloy is used for service up to ~600°C particularly in environments involving hot hydrogen gas. Flux CEWELD® FL 880

CLASSIFICATION

AWS	A 5.23: EB8
EN ISO	24598-A: S CrMo9
F-nr	6
FM	4

SUITABLE FOR ASTM: A 182 Gr F9, A 199 Gr T9, A 213 Gr T9, A 217 Gr C12, A 234 Gr WP9, A 335 Gr 9, A 336 Gr F9, A 387 Gr 9, EN (BS 3100 Gr B6), (BS 3604 Gr CFS 629-470, HFS 629-470), (BS 3604 Gr HFS 629-590, CFS 629-590), (DIN GS-12CrCrMo 10-1), (DIN X12CrMo 9-1), (DIN X7CrMo 9-1) W.Nr: 1.7386, 1.7388, 1.7389

APPROVALS CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

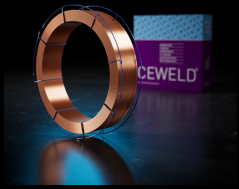
C	Si	Mn	P	S	Cr	Ni	Mo
0.08	0.4	0.6	0.01	0.01	8.7	0.18	1

MECHANICAL PROPERTIES

Heat Treatment	R _{PO,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
				RT		
730°C- 760°C 1h	540	660	19	55		HRc

REDRYING Not required

GAS ACC. EN ISO 14175



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SA 80S-B8 3,2MM

Packaging	KG/unit	EanCode
B-450	25	8720663416995