

ROYAL –ER 80 SB2 (ER 80SB2)

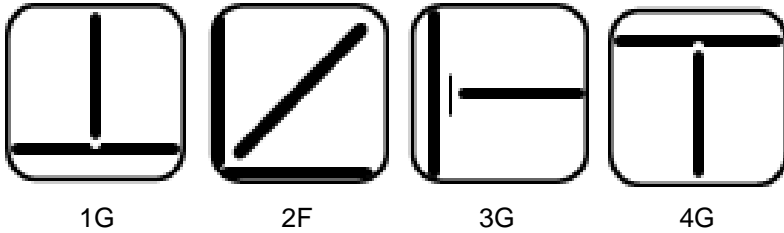
AWS /SFA A 5.28 ER 80SB2

Applications

It is used for joining of dissimilar combination of Cr-Mo and carbon steel or used similar component of tube, pipe welding.

Characteristics on Usage

It gives about 1.50 % Chromium and 0.50 % Molybdenum type weld deposit. The alloy is an air hardening material and therefore when welding with this filler wire rod ,preheat and post weld heat treatment are required

Welding Positions**Chemical Composition Of Weld Metal**

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo
0.07 -0.12	0.40 – 0.70	0.40 – 0.70	0.025Max	0.025Max	1.20 – 1.50	0.20 Max	0.40-

Mechanical Properties Of Weld Metal

(After PWHT at 620 ± 15°C for 1 Hr soaking)

U.T.S. (N/mm ²)	Y.S. (N/mm ²)	ELONGATION (L = 4d) %
550	470	19

Packing

Each Packets content 5 kg of Wire Rods having length 500 mm.,1000mm.