

PRODUCT DATA SHEET

MIG/TIG B2



MIG/TIG B2 is a low alloy solid wire, with 1,25% Cr and 0,5% Mo, designed for welding low alloy steels with high tensile strength and creep resistant steels. For welding ASTM A387 grade 11 and 12 and similar types employed for pipelines and pressure vessels with operating temperatures of approximately 500°C.

Classifications

AWS	A5.28	ER 80S-B2
EN	21952-A	G/W CrMoISi (nearest)
EN	21952-B	G/W 55 M ICM3

Typical Chemical Analysis

% Carbon	0,08	% Sulphur	0,01
% Manganese	0,6	% Chromium	1,3
% Silicon	0,6	% Molybdenum	0,5
% Phosphorous	0,01	% Copper	0,12

Typical Mechanical Properties

	*MIG	*TIG
Tensile Strength	570 MPa	590 MPa
Yield Strength	460 MPa	490 MPa
% Elongation on 5d	23	25
Charpy V-Notch at +20°C	150 J	250 J

* After PWHT of 1 hour at 690°C

Packing Data MIG (DC+)

Diameter (mm)	Current		Pack Mass (kg)	Item Number
	Amps (A)	Volts (V)		
0,8	140	22	15,0	W078280
1,0	230	25	15,0	W078282
1,2	280	26	15,0	W078284
1,6	300	26	15,0	W078286

TIG (DC-)

Diameter (mm)	Current		Pack Mass (kg)	Item Number
	Amps (A)	Volts (V)		
1,6	100	12	5,0	W078274
2,0	100	12	5,0	W078276
2,4	100	12	5,0	W078278

Suggested shielding gas: Argoshield® 5 (MIG), Argon (TIG)

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