

PRODUCT DATA SHEET

MIG/TIG B8



MIG/TIG B8 is a low alloy copper coated solid wire, with 9% Cr and 1% Mo, designed for welding creep resistant steels, for service temperatures up to 600°C. For welding ASTM A387 grade 9 and similar types that are employed in the chemical industry and in the ammonia synthesis process.

Classifications

AWS	A5.28	ER 80S-B8
EN	21952-A	G/W CrMo9
EN	21952-B	G/W 55 M 9CIM (nearest)

Typical Chemical Analysis

% Carbon	0,07	% Sulphur	0,008
% Manganese	0,5	% Chromium	9,0
% Silicon	0,004 [#]	% Molybdenum	1,0
% Phosphorous	0,008	% Copper	0,1*
[#] For MIG 0,008%		* For MIG 0,12%	

Typical Mechanical Properties

	*MIG	*TIG
Tensile Strength	670 MPa	670 MPa
Yield Strength	530 MPa	530 MPa
% Elongation on 5d	24	24
Charpy V-Notch at +20°C	60 J	250 J
* After PWHT of 1 hour at 745°C		

Packing Data MIG (DC+)

Diameter (mm)	Current		Pack Mass (kg)	Item Number
	Amps (A)	Volts (V)		
1,0	230	25	15,0	W078346
1,2	280	26	15,0	W078348

TIG (DC-)

Diameter (mm)	Current		Pack Mass (kg)	Item Number
	Amps (A)	Volts (V)		
1,6	100	12	5,0	W078340
2,0	100	12	5,0	W078344
2,4	100	12	5,0	W078342

Suggested gas for welding: Argoshield® 5 or Stainshield® Plus (MIG), Argon (TIG)

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