

UNISCO 80S-B2 MIG/TIG

Specification AWS/SFA 5.28 ER 80 S-B2

Typical chemical composition of wire [%]	C	Si	Mn	Cr	Mo
	0,09	0,55	0,55	1,35	0,50

Bruscato-Factor < 15 ppm can be guaranteed

Description Suitable for high-quality weldments on low alloyed creep resistant steels. Also suitable for joining dissimilar combinations between Cr-Mo and carbon steels. In the GMAW-process all modes of metal transfer can be used. Preheating and control of interpass temperature are necessary.

Base materials i.e. 13 CrMo 4-5 (material no. 1.7335)

Typical mechanical properties	Yield Strength (R_e)	≥ 470 N/mm ²
	Tensile strength (R_m)	≥ 550 N/mm ²
	Elongation (A) ($L_o = 5 d_o$)	≥ 19 %

delivery condition GMAW: spooled acc. EN 759
TIG: rods acc. customer specification