



AUTOMIG 80S-B6

GMAW LOW ALLOY STEEL (High Temperature)

AWS A/SFA 5.28 **ER80S-B6**

CLASSIFICATION:

EN ISO 21952-B
G 55 M13 5CM

IS 6419
SLA-5-M-531

KEY FEATURES:

- Copper coated low alloy steel solid filler wire & rod
- Uniform copper coating
- Recommended pre-heat and interpass temperature 350-450°C
- Typical 5 Cr-0.5 Mo weld deposit
- Air hardenable alloy resistant to creep at elevated temperature up to 650°C
- Radiographic quality weld

APPROVALS: CE

TYPICAL APPLICATIONS:

- Welding of 5 Cr-0.5 Mo creep resistant steels and equivalent grades
- Application in power generation, ammonia synthesis plants and petrochemical industries
- Joining P5/T5 materials of similar composition
- Joining P5B materials e.g. SA 336/336M Gr.F5, SA 387/387M Gr.5



TYPICAL CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt %:

C	Mn	Si	Cr	Mo
0.08	0.5	0.35	5.5	0.5

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%
Typical	PWHT: 745°C for 1 hr	620	520	21

PARAMETERS - PACKING DATA:

Ø, mm	Kg/Spool		
1.2	15	 DCEP STORAGE / HANDLING : Keep dry and follow handling instructions mentioned on the box	All Positions 
1.6	15		

Shielding Gas	Gas Flow Rate, LPM
Ar/1-5O ₂	15-22